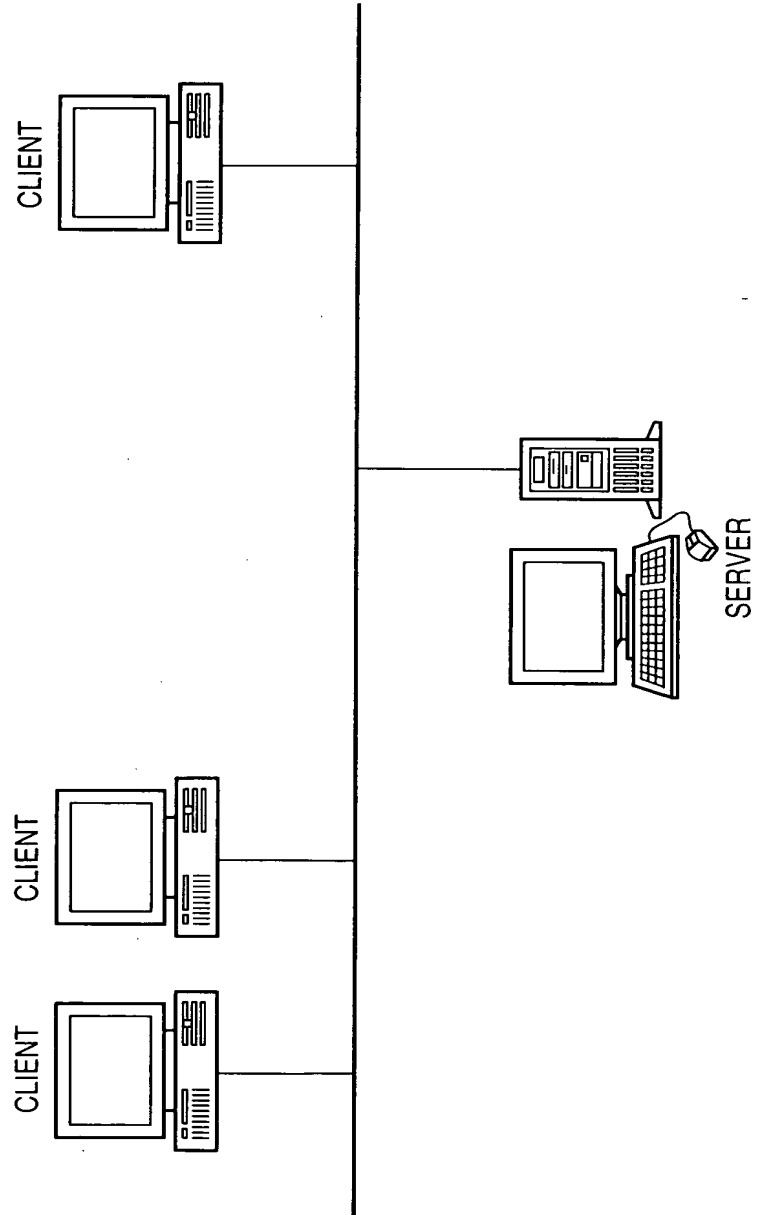


FIG. 1



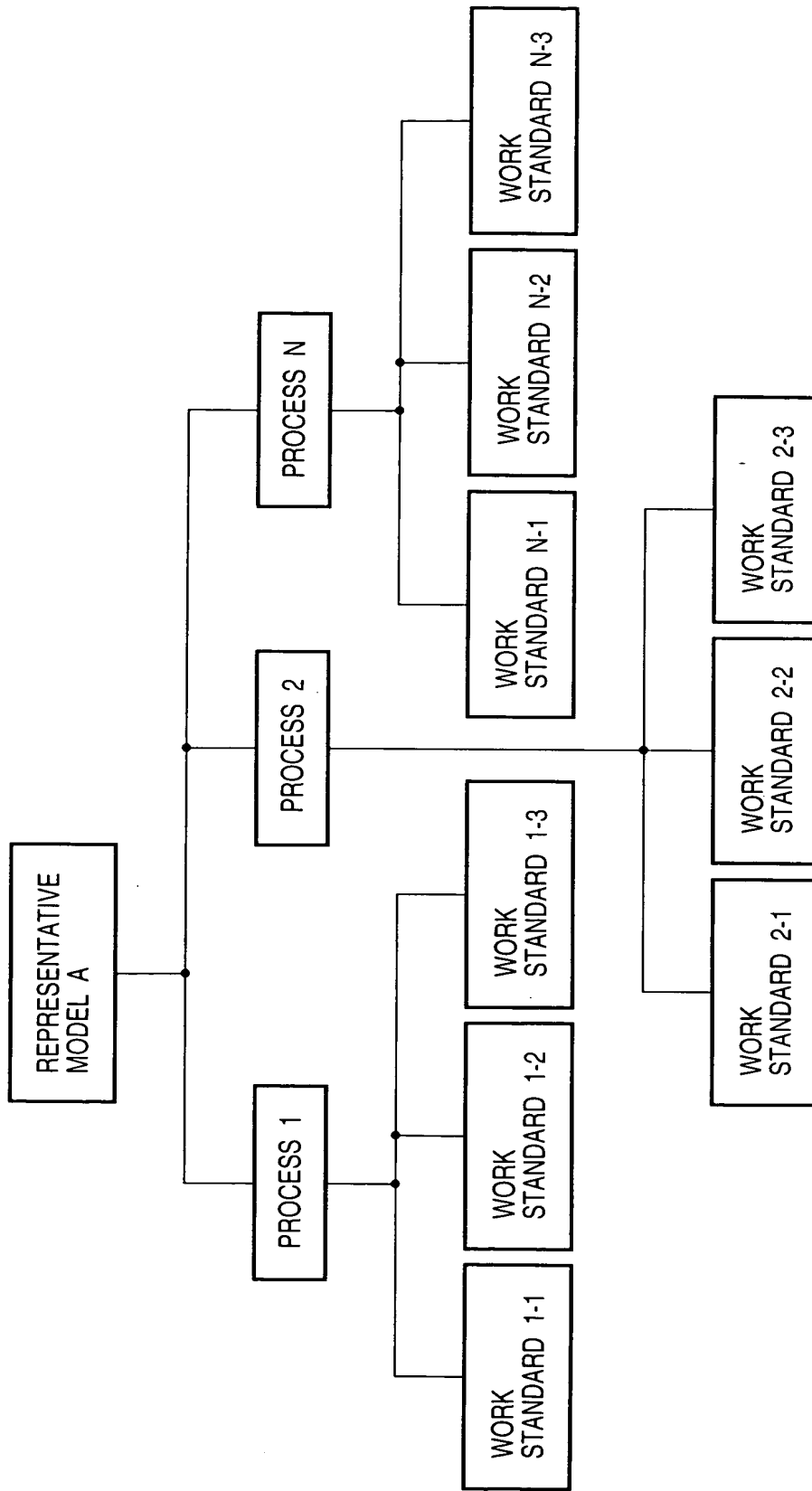


FIG. 2

3/97

FIG. 3

301
300

WORK STANDARD 01 CREATION
302

APPLIED
303

PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY
304			305		

TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL	QUANTITY	CHECK ETC.
	306	307
		308

309
313

No.
WORK PROCEDURE
No.
NOTE / STANDARD ETC.

310
311

311
312

REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME
01	CREATED	1997/09/25			

MANAGEMENT NO.

FIG. 4

STRUCTURE OF MASTER FILE

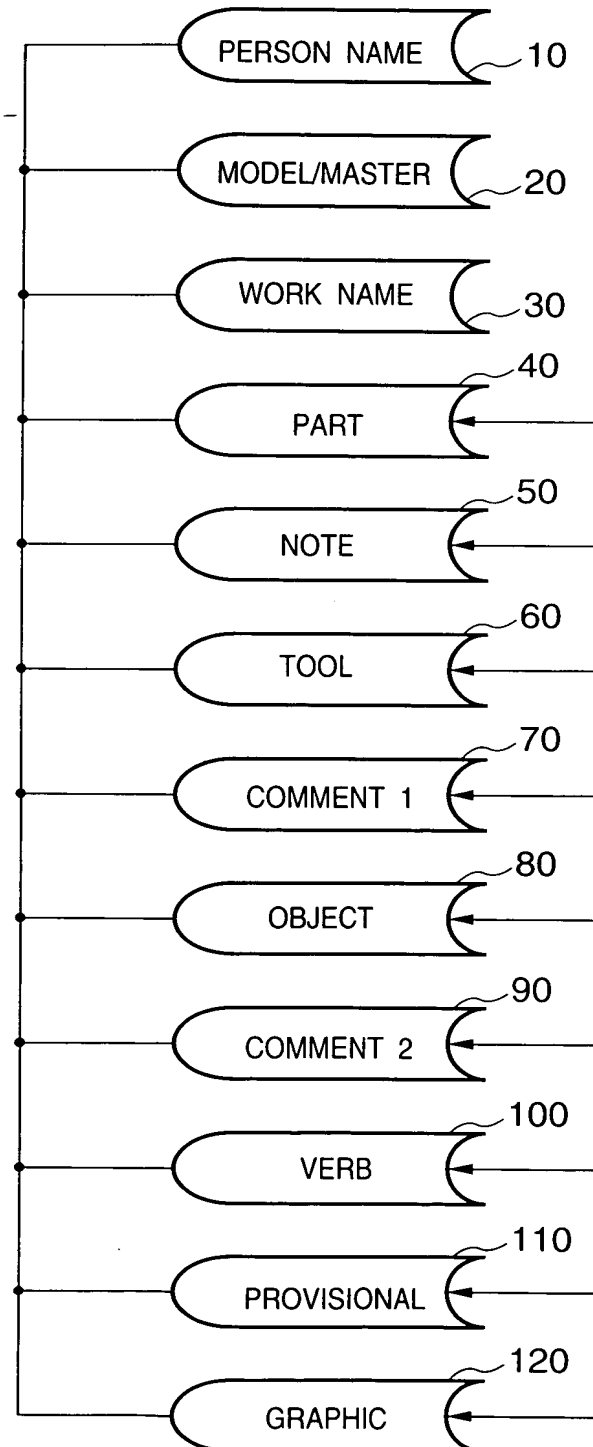


FIG. 5

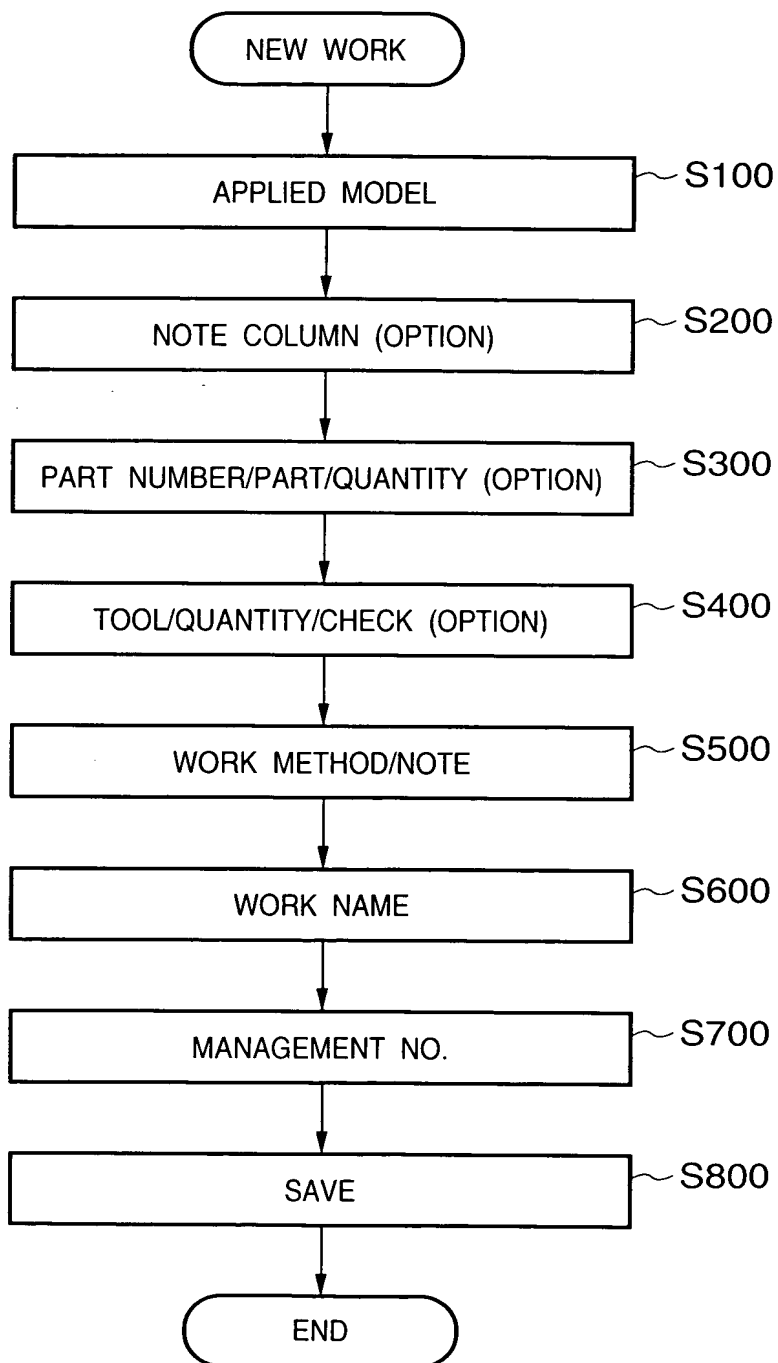


FIG. 6

SELECTION OF APPLIED MODEL
LIST OF APPLIED MODELS
BJC-4200 SYSTEM
BJC-420J
BJC-420J (BLACK)
BJC-4300
BJC-430J
BJC-4200LX
A250 II Q
BJC-4200
OK
CANCEL

FIG. 7

WORK STANDARD 01 CREATION				<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
APPLIED				BJC-420J BJC-420J(BLACK) BJC-430J							
PART NUMBER		PART NAME		QUANTITY		PART NUMBER		PART NAME		QUANTITY	

302

8/97

FIG. 8

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001	▲	
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101		
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001	▼	

FIG. 9

• WORK NAME

GE ____

• CANDIDATES

原稿(GENKO)ガラス保護紙セット(SET ORIGINAL GLASS PROTECTIVE SHEET)

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))

原稿(GENKOU)台ガラスセット(SET ORIGINAL GLASS TABLE)

原稿(GENKOU)台保護紙セット(SET ORIGINAL TABLE PROTECTIVE SHEET)

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 10

• WORK NAME

現像(GENZOU) ____

• CANDIDATES

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING
RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING
RAIL RETURN SPRING(AFTER))

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER
IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN
DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1101 (COMMENT 1)

1102 (OBJECT) ~を

1103 (COMMENT 2)

1104 (VERB) ~する

00 ※

01

1105a

1105b

1105

NOTE, STANDARD / REQUIRED QUALITY :

1106

1107

1108

OK CANCEL

12/97

FIG. 12

WORK STANDARD SYSTEM	
WORK NAME :	
WORK METHOD :	
	1201
	1202
00 ※	1105b
01	

FIG. 13

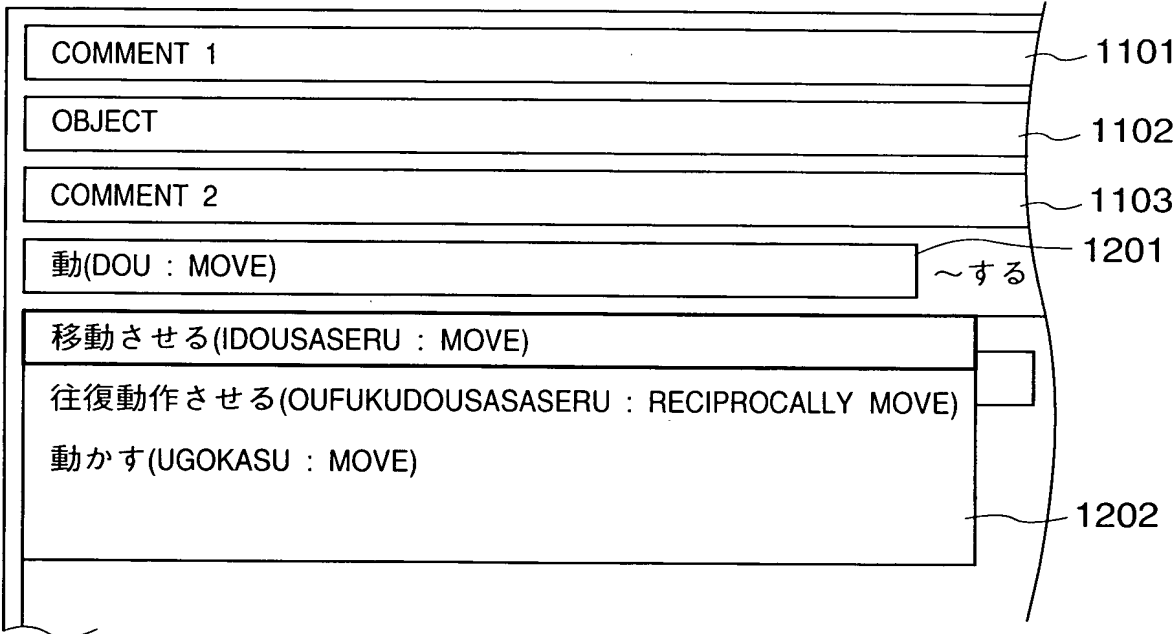
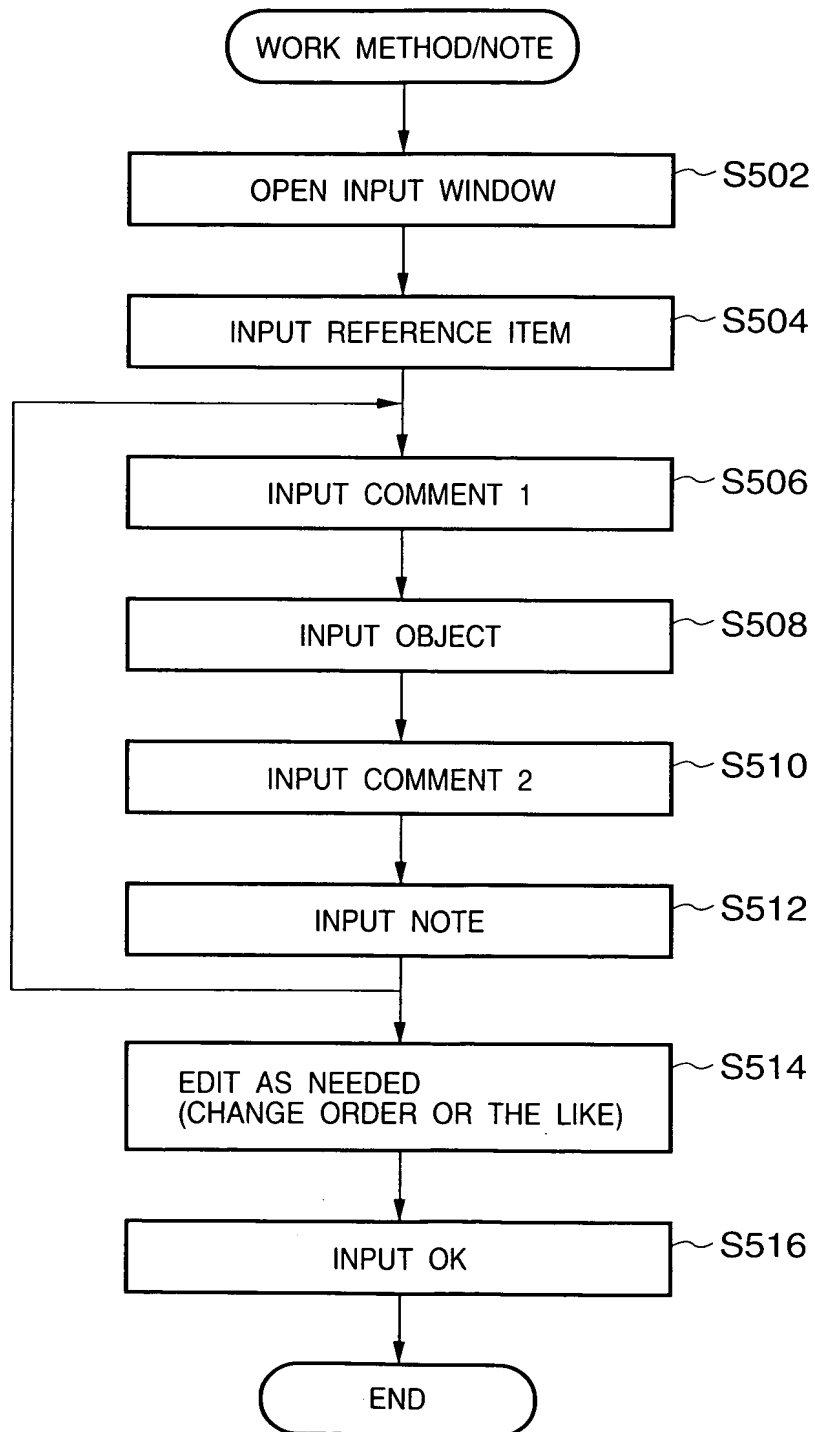


FIG. 14

15/97

FIG. 15

00	※	
01	DO zzzz SUCH THAT xxxx AT wwww POSITION BECOMES yyyy	
02	WIND AV CORD	
03	CONFIRM 100V SYSTEM	
04	SET CRG HOLDER	

FIG. 16

NOTE, STANDARD / REQUIRED QUALITY

NOTE

SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASF_u
 DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE
 DON'T HOOK PAPER GUIDE u ON SHEET HOLDER
 BEWARE OF IMITATIONS
 BEWARE OF IMITATIONS(Color Style Write

1601

1602

FIG. 17

NOTE, STANDARD / REQUIRED QUALITY	
1	NOTE

1107

FIG. 18

CONFIRM	
00 ※	
01 CONFIRM 100V SYSTEM	
02 WIND AV CORD	CUT(I)
03 SET CRG HOLDER	COPY(C)
04	PASTE(P)
	ADD(A)
	DELETE(D)
	UNDO
	REVISE(CHANGE)
	REVISE(DELETE)
NOTE, STANDARD / REQUIRED QUALITY	

1802

CONFIRM	～する
00 ※	
01 WIND AV CORD	
02 CONFIRM 100V SYSTEM	
03 SET CRG HOLDER	
04	

NOTE, STANDARD / REQUIRED QUALITY

NOTE, STANDARD / REQUIRED QUALITY

FIG. 20

CONFIRM	
00 ※	
01 WIND AV CORD	
02 SET CRG HOLDER	
03	<div> <div>CUT(I)</div> <div>COPY(C)</div> <div>PASTE(P)</div> <div>ADD(A)</div> <div>DELETE(D)</div> <div>UNDO</div> <div>REVISE(CHANGE)</div> <div>REVISE(DELETE)</div> </div>
NOTE, STANDARD / REQUIRED QUALITY	

1802

21/97

FIG. 21





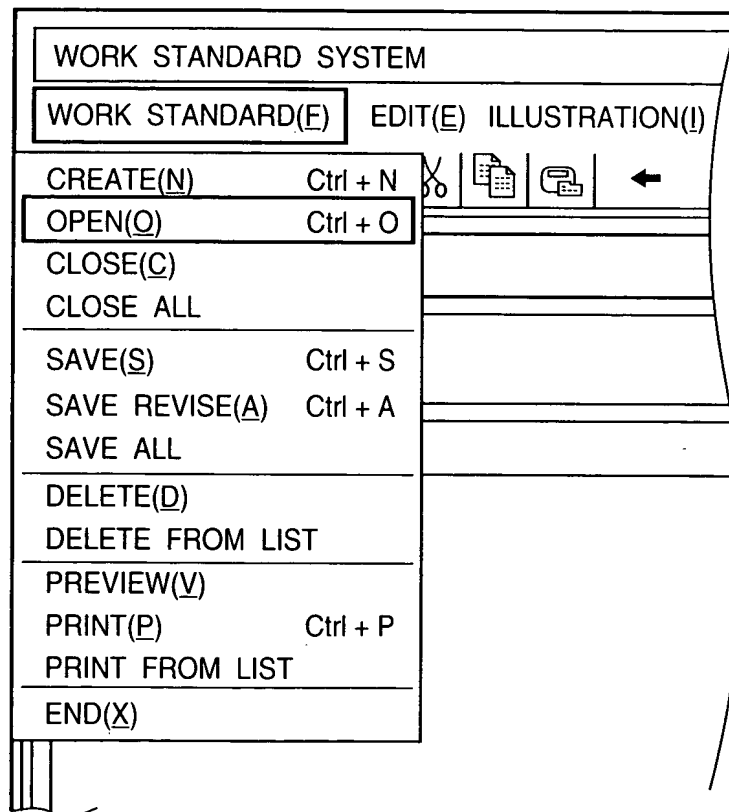




WORK STANDARD SYSTEM	
WORK STANDARD(F)	EDIT(E) ILLUSTRATION(I) SHIPMENT DESTINATION
CREATE(N) Ctrl + N	   
OPEN(O) Ctrl + O	
CLOSE(C)	
CLOSE ALL	
SAVE(S) Ctrl + S	
SAVE REVISE(A) Ctrl + A	
SAVE ALL	PART
DELETE(D)	
DELETE FROM LIST	
PREVIEW(V)	
PRINT(P) Ctrl + P	
PRINT FROM LIST	
END(X)	

FIG. 22



CANCEL

FIG. 24

SYSTEM			
EDIT(E)		ILLUSTRATION(I)	SHIPMENT DESTINATION(S)
		VIEW(V)	 
01 CREATE		EDIT(E)	
		PowerPoint	
		✓ Canvas	

302

WORK STANDARD 01 CREATION									
APPLIED									
PART NUMBER		PART NAME							
303									
TOOL / TREATMENT DEVICE									
WORK PROCEDURE									
No.	2501		2502		2503		2504		
FILE NAME :									
CLOSE									
UPDATE									
CLEAR									
WORK NAME									
MANAGEMENT NO.									
REVISION NUMBER		CONTENTS OF REVISION		DATE		PERSON IN CHARGE		APPROVE	
01		CREATED		1997/09/25					

FIG. 26

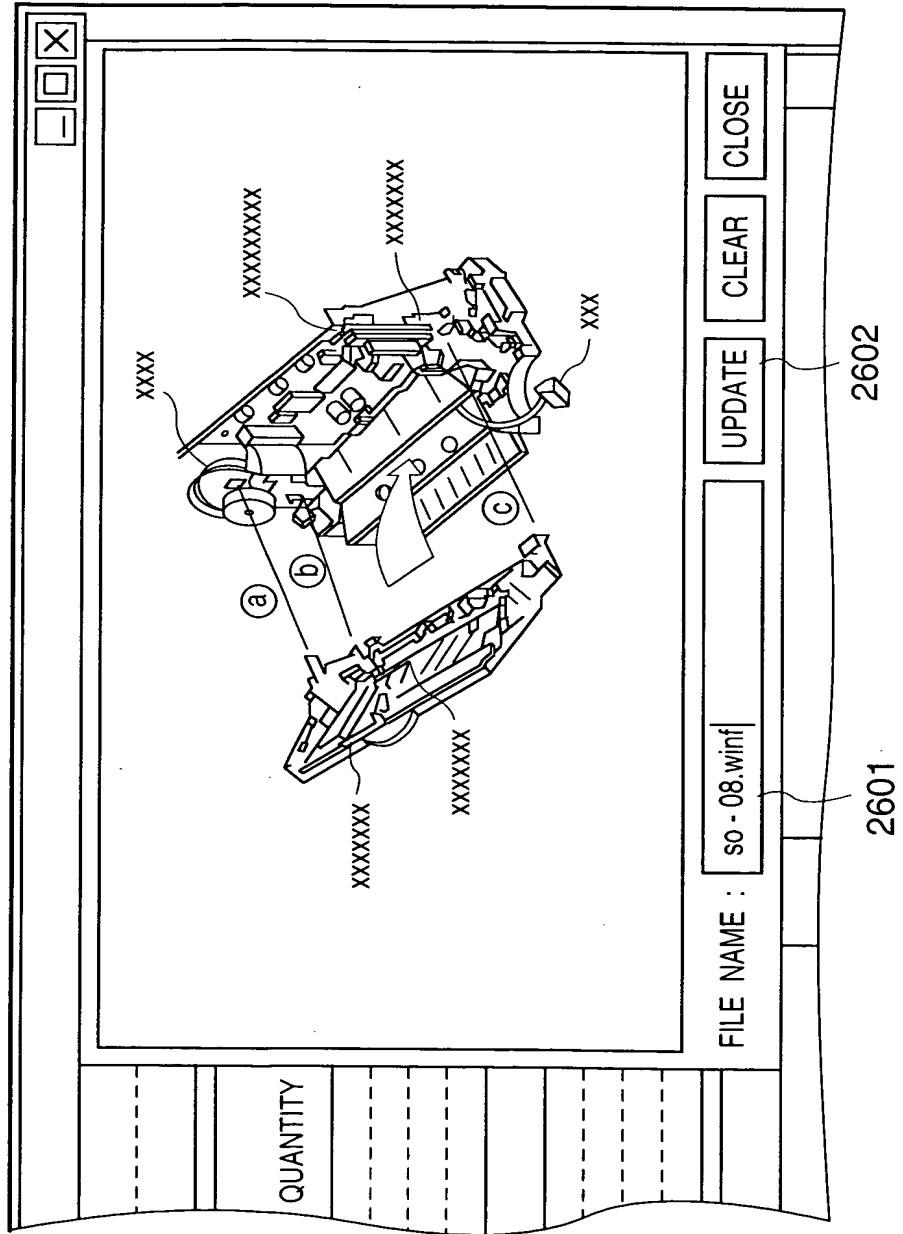


FIG. 27

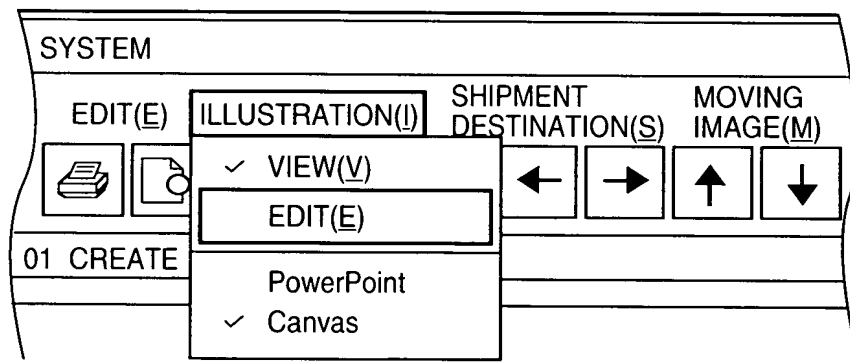


FIG. 28

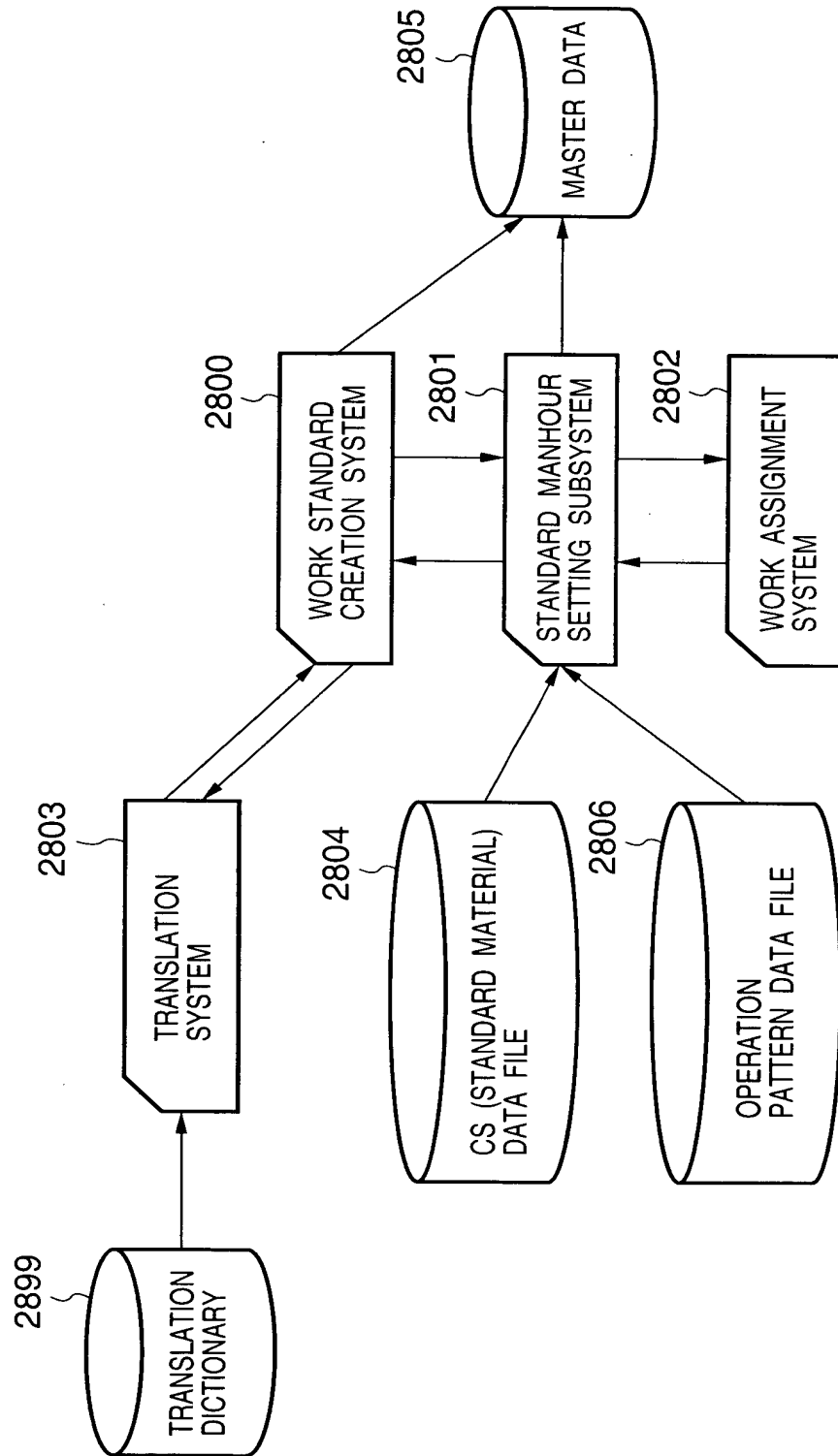


FIG. 29

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) [X]

☒ WORK STANDARD DATA

☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

FIG. 30

3001 3002 3003 3004

TRANSLATION OF WORK STANDARD

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

☐ TOTAL
☒ ASSEMBLY
☐ UNIT
☒ ASSEMBLY

DISPLAY DATA

☒ ALL
☐ UNTRANSLATED
☐ UNCHECKED

DISPLAY LANGUAGE

☐ JAPANESE
☒ ENGLISH

3000

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION	CHECK
PT - 010 - 010	01	クリーナu取付	X	X
PT - 010 - 020	01	クリーナu取付	X	X
PT - 010 - 030	01	クリーナu取付	X	X
PT - 070 - 030	01	切換アームAssy組立	X	X
PT - 080 - 010	01	伝達ローラu取付	X	X
PT - 090 - 010	01	伝達ローラu取付	X	X
PT - 100 - 010	01	紙押え取付	X	X

3006

3007 3008 3005

3000

FIG. 31

TRANSLATION OF WORK STANDARD (PROTOTYPE)									
WORK STANDARD(E) ILLUSTRATION(I) VOICE(S) WINDOW(W)									
WORK STANDARD PN-030-020 01 New created by (PX2056) A252 PUMP UNIT									
Model	QG5-1319								
Part No.	Part Name	Qty	Part No.	Part Name	Qty				
Total					Qty	PN			
No.	Procedure				No.	Precaution / Conditions			
01	The blade lever spring hooks to ① of the blade lever.				02 - 01	No Table Data 1			
02	Side the blade lever in the direction of arrow ② and check there is no catch and nor the return by the spring force.				03 - 01	No Table Data 1			
03	Check press-fitting the blade lever shaft leading edge to the braid folder leading edge.								
Details is of Revision		Data	By	OK	Procedure				
01 New Created by (PX2056)					No Table Data 1				
					Page No.				
					PN-030-020				

3101

FIG. 32

3200

WORK PROCEDURE ✕	
VOICE(W)	
JAPANESE	
WORK PROCEDURE	
3201	ブレードレバーハネをブレードレバーの ① 部に引っ掛ける
3202	01 ブレードレバーハネをブレードレバーの ① 部に引っ掛ける 02 ブレードレバーを矢印 ② 方向にスライドさせ引っ掛かり無くハネ力で戻ることを確認する 03 ブレードレバー軸先端がブレードホルダー先端まで圧入されていることを確認する
ENGLISH	
Procedure	
3203	The blade lever spring hooks to ① of the blade lever.
3204	01 The blade lever spring hooks to ① of the blade lever. 02 Side the blade lever in the direction of arrow ② and there is no catch, and n.... 03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....
<div style="display: flex; justify-content: space-between; width: 100%;"> ◀ ▶ </div> <div style="display: flex; justify-content: space-around; width: 100%;"> <div style="border: 1px solid black; padding: 2px 10px;">TRANSLATE</div> <div style="border: 1px solid black; padding: 2px 10px;">OK</div> <div style="border: 1px solid black; padding: 2px 10px;">CANCEL</div> </div>	

TRANSLATION OF WORK STANDARD (PROTOTYPE)		<div> <div></div> <div></div> <div></div> </div>	
WORK STANDARD(E) ILLUSTRATION(I)		VOICE(S)	DOW(W)
WORK STANDARD PN-030-020 01 New		PLAY(P)	XPX2056) A252 PLATEN UNIT
		NEW(N)	
Model QG5-1317		DRIVE(D)	

FIG. 34

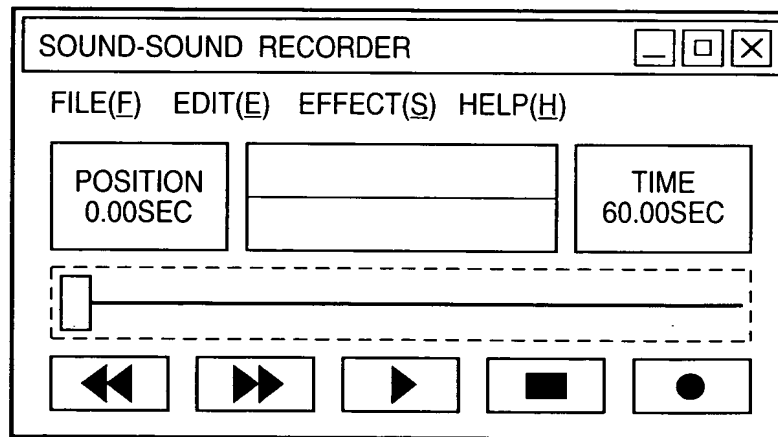


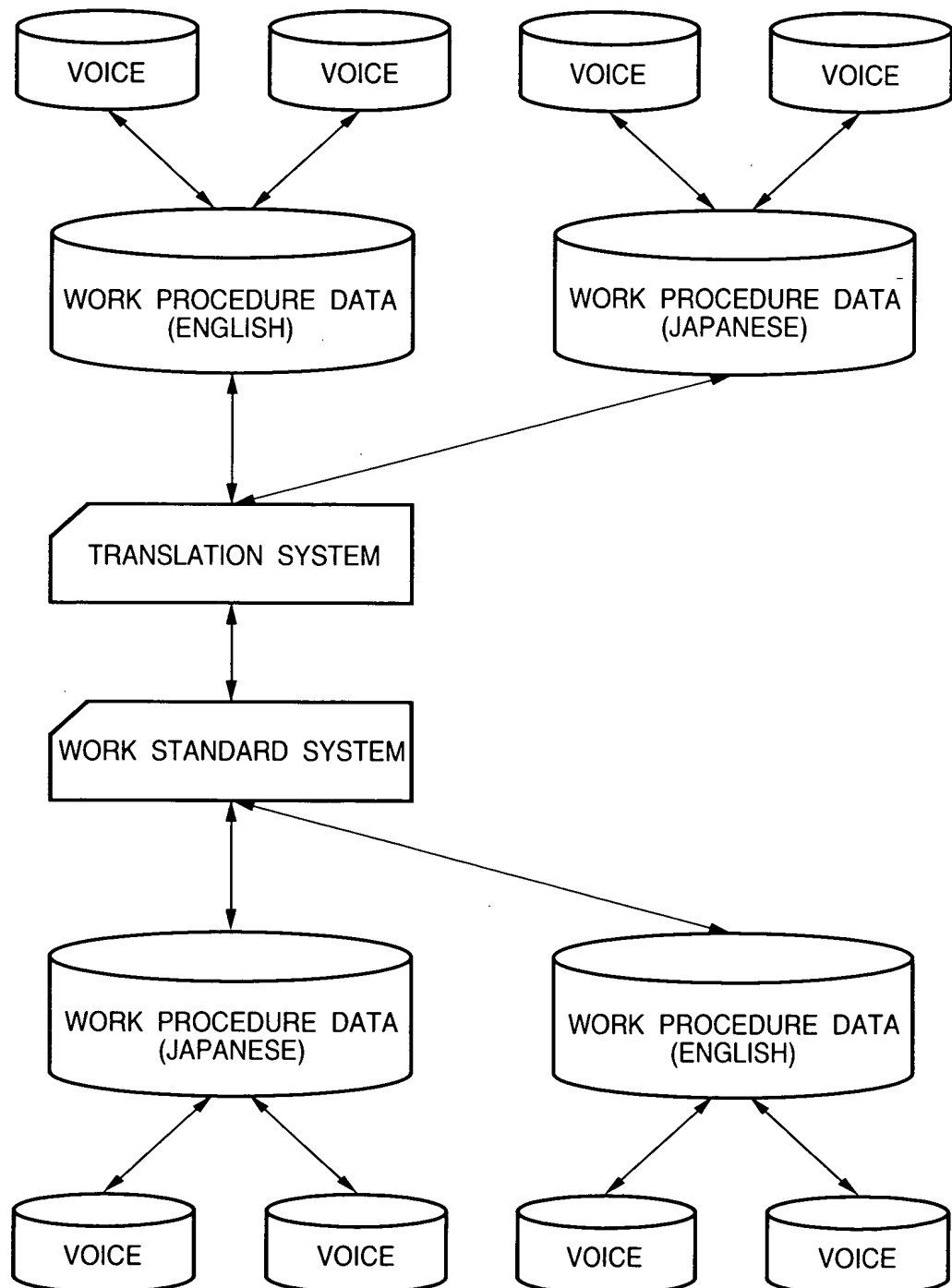
FIG. 35

FIG. 36

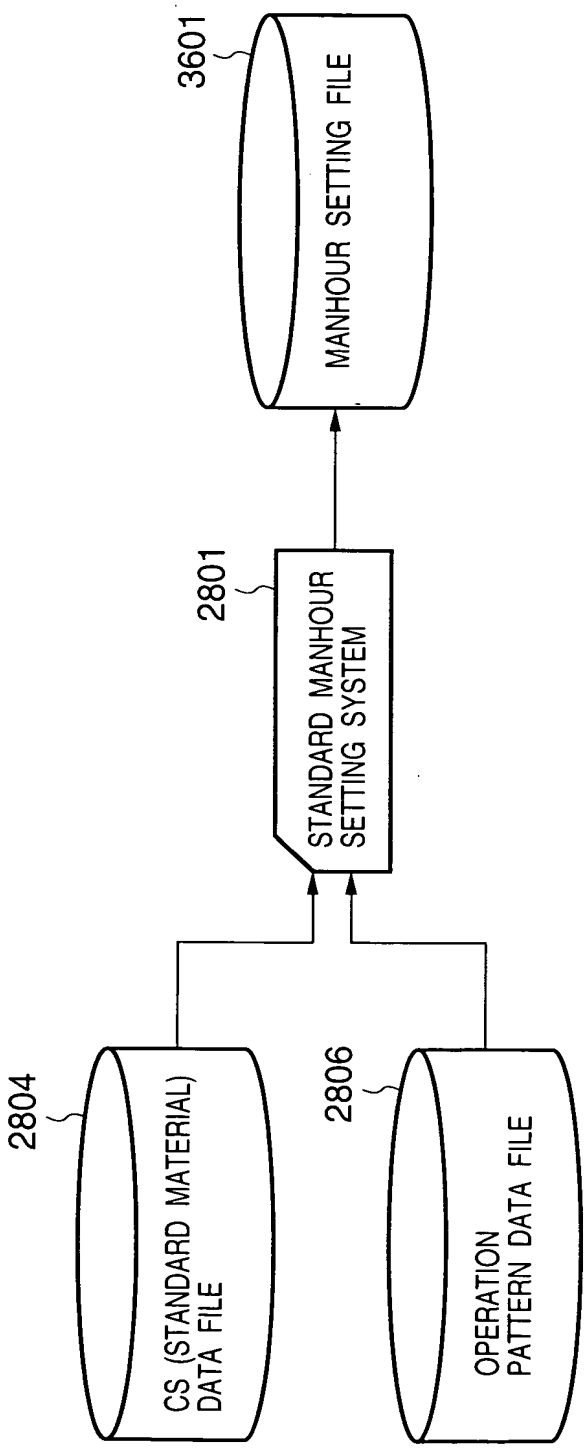


FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY	MANHOUR	CS	SET CONDITION

FIG. 38

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39

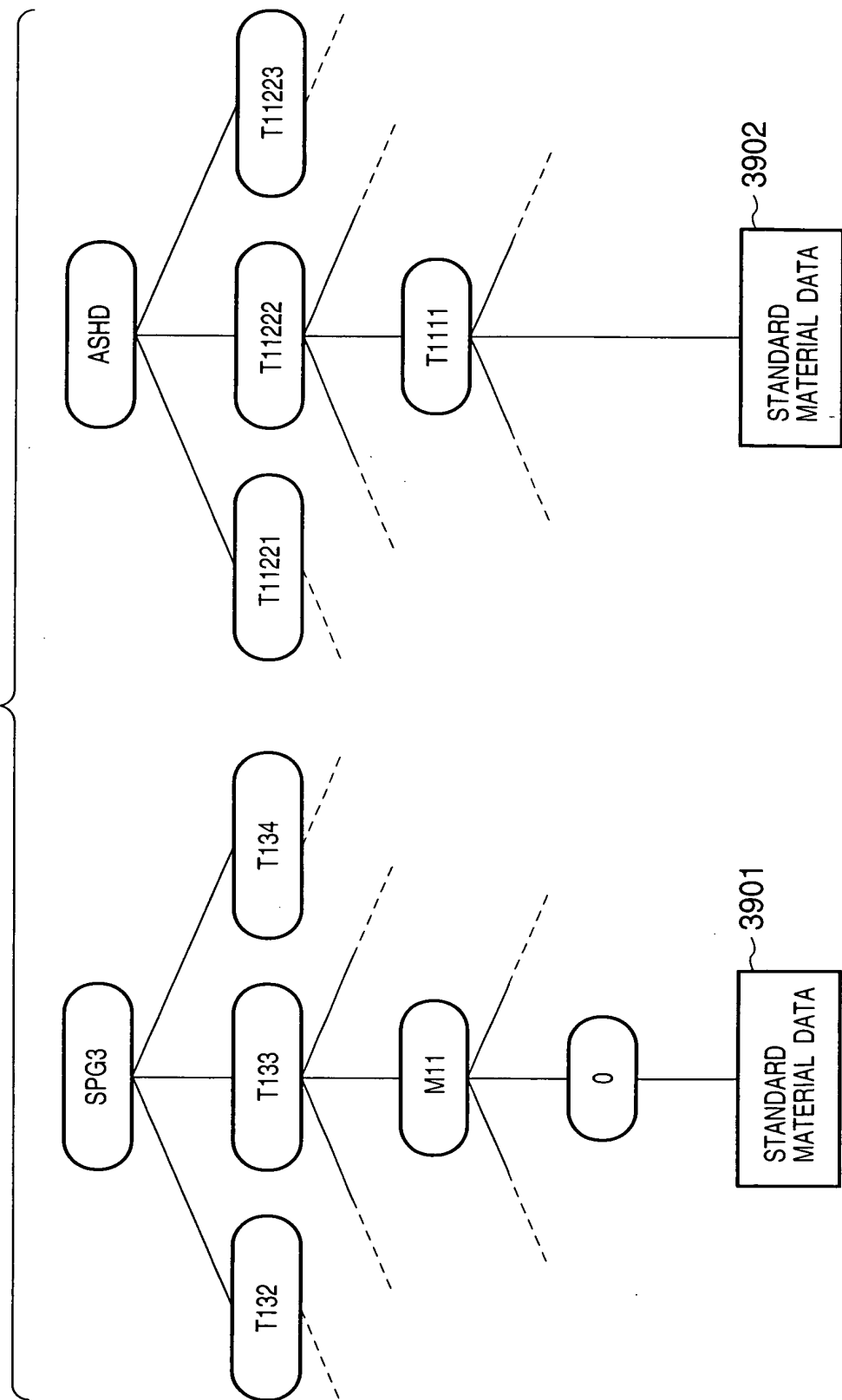
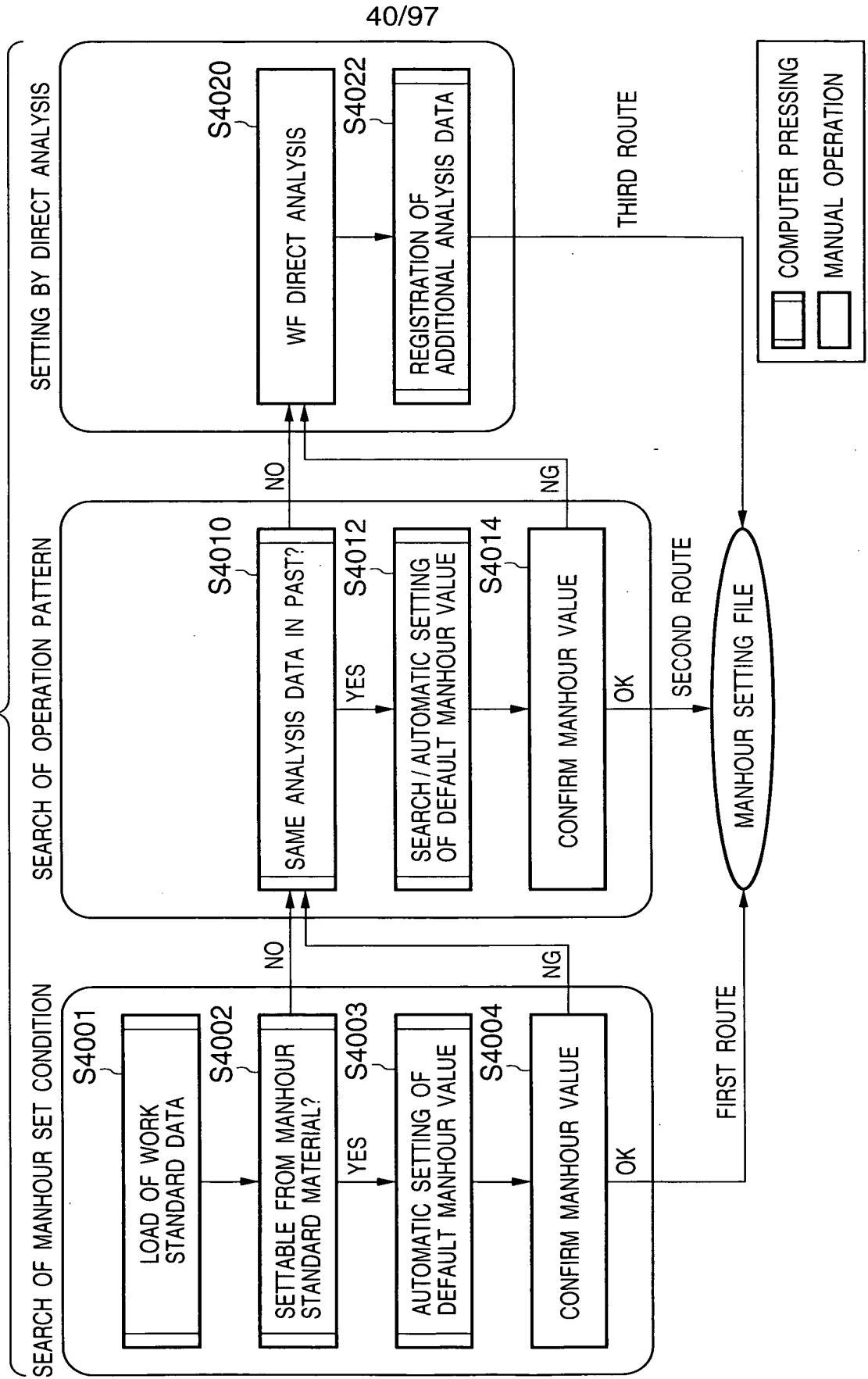


FIG. 40



[illegible]

DATA LOAD

No.	COMMENT 1	OBJECT	COMMENT 2	VERB
1		負荷バネを	負荷バネ取付治具に	組込む
2	治具の	SWを		ONする
3		分離ロー軸を	負荷バネ取付治具に	組込む
4	治具の	SWを		OFFにする
5		分離ロー軸を	治具より	外す

3601

SEARCH KEYWORD(KW)

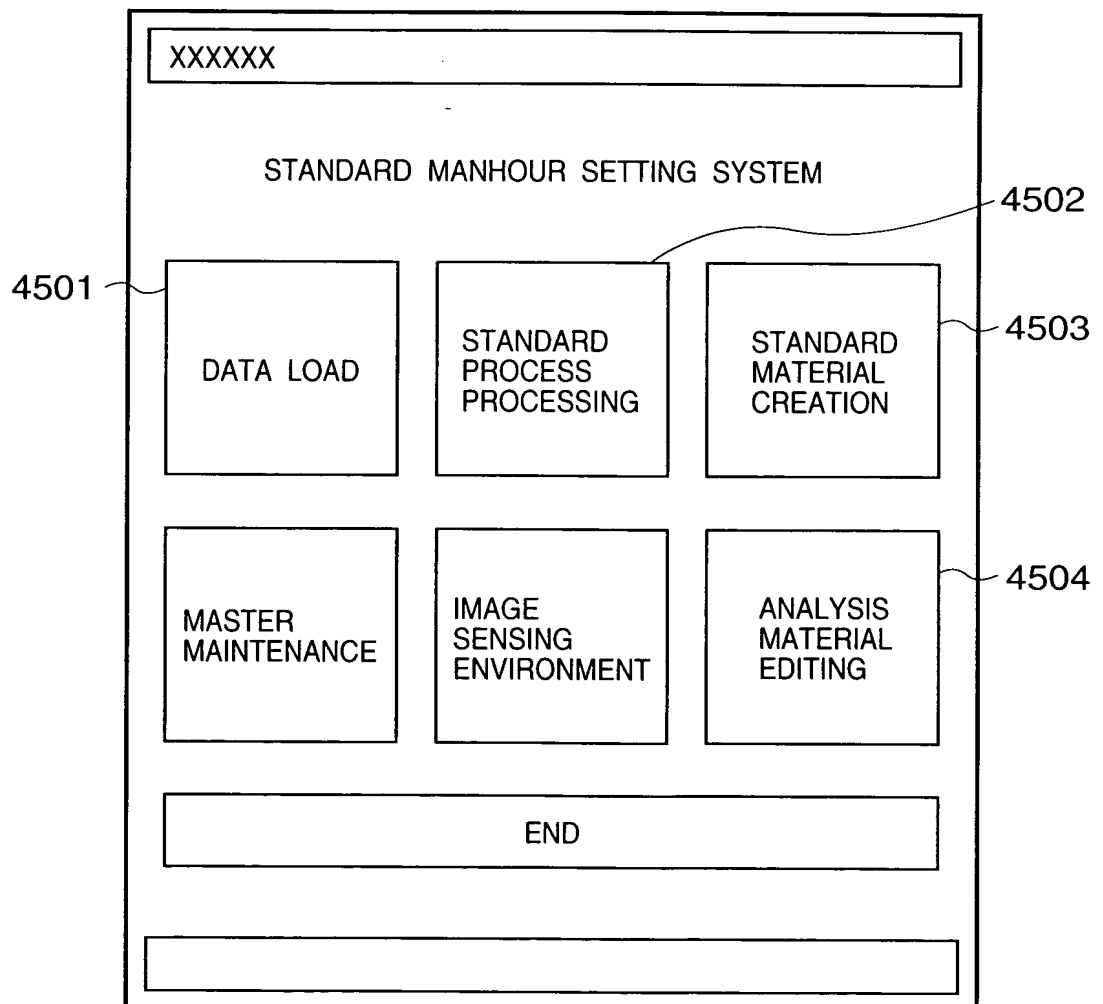
No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	*バネを	*に	組込む	SPG3 T133 / M11 / 0	41RU
2	*	*を	*に	組込む	ASHED T11222 / T1111	37RU
3	*	*を	*より	外す	PUMQ T2111 / T111111	16RU
4	*	*Eリングを	*	組込む	RIN2 T11211 / SO	76RU
5	*	*コネクタを	*	差し込む	CONN T11211 / SO	41RU
6	*	*	*	増し締めする	SCR6 M211 / 1	23RU

[illegible]2806 ~ 

FIG. 44

[illegible]

FIG. 45



4609 4610

4601

XXXXXXXX

ALL O DESIGNATE

PRODUCT NUMBER

WORK STANDARD

PRODUCT SYMBOL

PREVIOUS LOAD DATE

0 - CLOCK

XXXXXX

xyz - test

test - 01

tesr - AMI

XXXX

BL - OLD

SET IN 1996

XXXX

SET IN 1996

SET IN 1996

XXX

SELECT

CANCEL

OK

4611 4602 4603 4604 4605





4705a 4705b

FIG. 48

4805 4804

LOAD OF DATA

4800

COMPONENT DESIGNATION

4801

☐ ALL

☒ DESIGNATE COMPONENT

4802

CH

AUTOMATIC MANHOUR SETTING

4803

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

EXECUTE

CANCEL

4806

FIG. 49

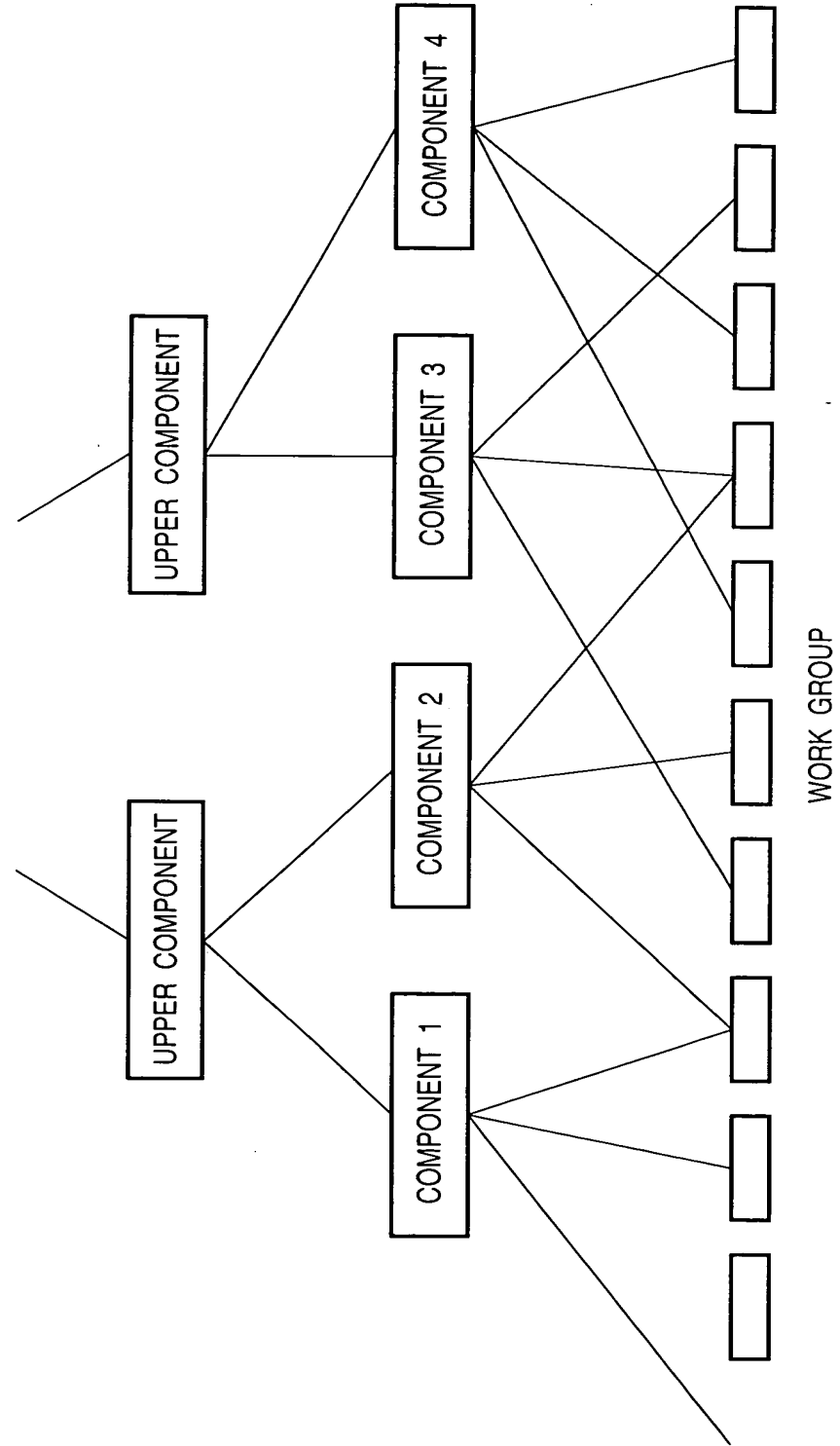


FIG. 50

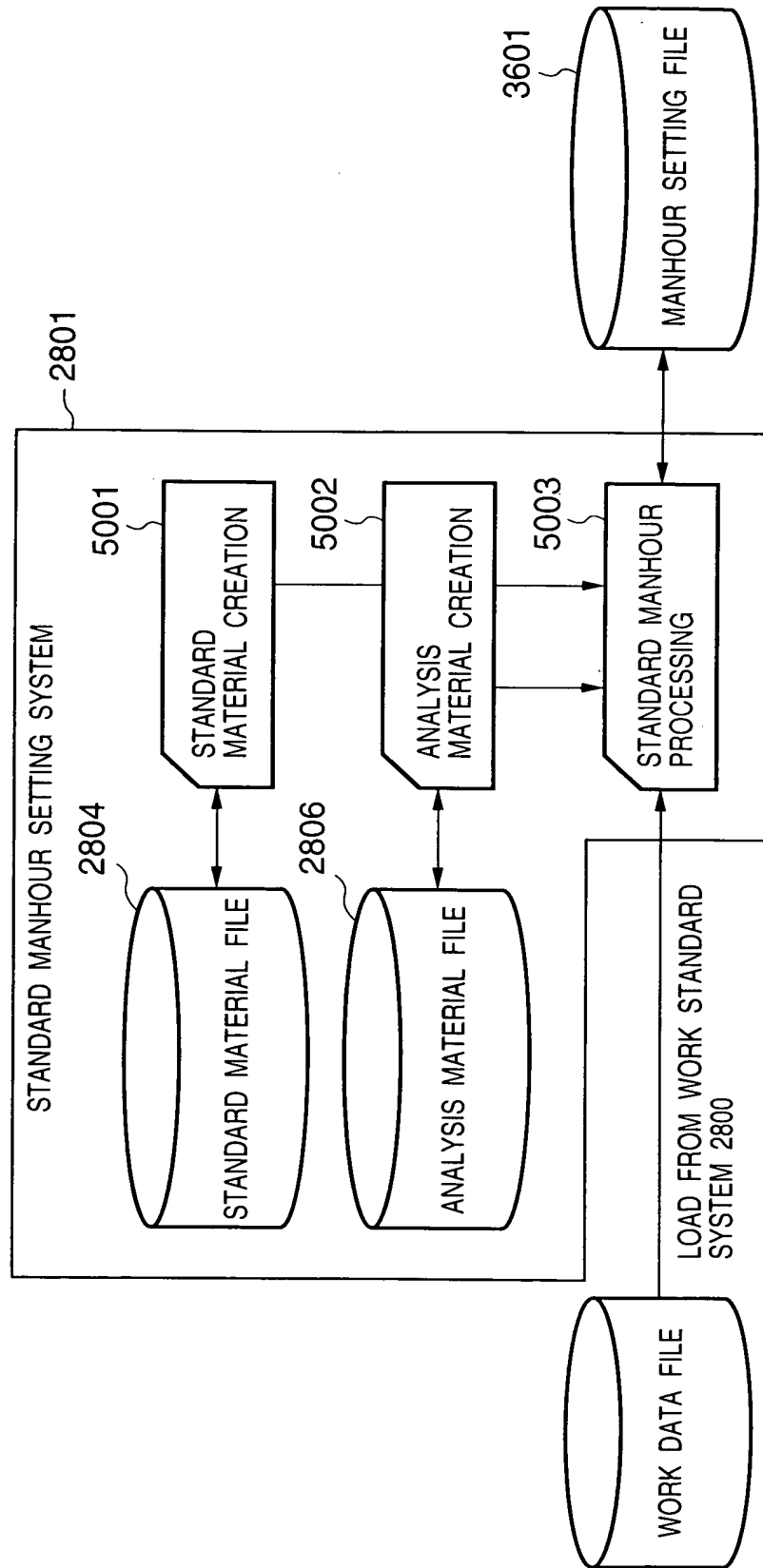
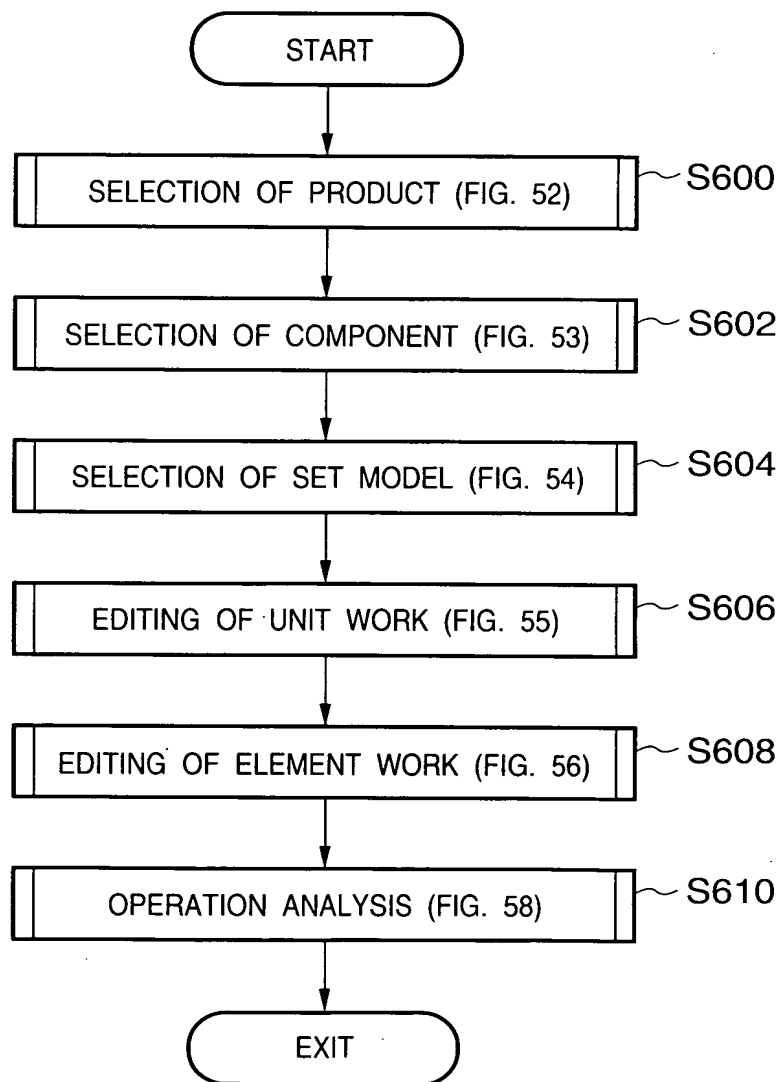


FIG. 51



—

5201

[The page contains faint, illegible markings or bleed-through from the reverse side.]

5301

(The following are the names of the persons who have been appointed as members of the Board of Directors of the National Association of Manufacturers since the last meeting of the Board.)

[illegible]

FIG. 55

SELECTION OF MODEL

FILE(F) EDIT(E) VIEW(V)

FILE(F)
EDIT(E)
VIEW(V)

PRODUCT SYMBOL : BJ - 970909

NAME : 097 - 09 - 09 LOAD

SET MODEL SYMBOL : BJC - 4300

COMPONENT SYMBOL : ON

NAME : xxxxxx

LATEST¹
REVISION NUMBER

UPDATE
DISPLAY

S	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY
N ¹ 3	CH-01-01	1	電気チェック	0	0	0	1
N ¹ 4	CH-01-02(1)	1	電気チェック	0	0	0	1
N ¹ 5	CH-01-02(2)	1	電気チェック	0	0	0	1
N ¹ 6	CH-01-03	1	電気チェック	0	0	0	1
N ¹ 7	CH-01-04	1	電気チェック	0	0	0	1

N ¹ 23	CH-07-02(1)	1	フロントカバーu取付	0	0	0	1
N ¹ 24	CH-07-02(2)	1	フロントカバーu取付	0	0	0	1
N ¹ 25	CH-07-01(3)	1	フロントカバーu取付	0	0	0	1
N ¹ 26	CH-07-01(4)	1	フロントカバーu取付	0	0	0	1

No. FORMAL MANAGEMENT NO.

UNIT WORK NAME

MANHOUR

USE

FREQUENCY

1

2

3

4

5

3 CH-01-01

ELECTRICAL CHECK

0

0

0

1

◎ CHANGE ○ INSERT ○ ADD

OK

5501 5507 5506 5502 5503 5504 5505

55/97

FIG. 56

XXXXXX									
<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="display: flex; gap: 5px;"> <div style="border: 1px solid black; padding: 2px 5px;">🏠</div> <div style="border: 1px solid black; padding: 2px 5px;">📄</div> <div style="border: 1px solid black; padding: 2px 5px;">✖</div> <div style="border: 1px solid black; padding: 2px 5px;">📁</div> </div> <div style="border: 1px solid black; padding: 2px 5px;">🔍</div> </div>									
FORMAL MANAGEMENT NO. PU-03-01			UNIT WORK NAME : MOTOR ATTACHMENT			TOTAL MANHOUR :		<div style="border: 1px solid black; padding: 2px 10px; display: inline-block;">0</div> <div style="border: 1px solid black; padding: 2px 10px; display: inline-block; margin-left: 10px;">NEXT UNIT WORK</div>	
NO.	ELEMENT WORK NAME	REVISION	MANHOUR	USE	CS	SET CONDITION			
▶ 1	LFモータのケーブルと反対側の軸にダブルギア	1	0	0					
*									
<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>COMMENT 1 : LFモータのケーブルと反対側の軸に</p> <p>OBJECT : ダブルギアを</p> <p>COMMENT 2 : ギア径の小さい方から</p> <p>VERB : 取付ける</p> </div> <div style="width: 50%; text-align: right;"> <div style="border: 1px solid black; padding: 5px; display: inline-block;">設定</div> </div> </div>									

✕
☐
☐

FILE(F) EDIT(E) VIEW(V)

ALL

TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR	USE	FREQUENCY	COUNT	SET DATE
▶	IP-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	0	97/09/09 9:52
	IP-キャップ:	本体を	矢印1の様に	入れる	-50/E/02/N/-6	11	0	1	0	97/09/09 9:53
	IP-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	0	97/09/09 9:55
		要素作業01		動詞	-50/Gr1/N/>6/-3	15	0	1	0	97/09/10 16:34
	IP-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	0	97/09/10 19:09
		キャリッジ・ロク		塗布する	Time100/Rate100	100	100	1	1	97/09/10 19:16
	モーター組立:	アリンダジャーシ		入れ、セツする	M211/1/10	50	1	1	1	97/09/11 17:00
		アリンダジャーシ		裏面にする	T1221/M2311/0/0	12	0	1	0	97/09/11 17:34
		1		1	T2221/M1211/0/1	24	0	1	0	97/09/11 17:20
		2		2	T1221/M2311/0/0	12	0	1	0	97/09/11 17:24
		アリンダジャーシ	PRカ'イト'取付る	セツする		15	0	1	0	97/09/12 11:24
		dgdlatdlat		fdasfdasfdad	*	16	0	1	0	97/09/12 12:10
		dscsfdsfdsaf		fsafsdadfdas	T2121/M1111/0/1	13	0	1	0	97/09/12 12:10
		dgdlatdlat		fdasfdasfdad	*	16	0	1	0	97/09/12 13:39
		アリンダジャーシ	PRカ'イト'取付る	セツする		15	0	1	0	97/09/12 14:00
		アリンダジャーシ	PRカ'イト'取付る	セツする		15	0	1	0	97/09/12 14:00
		アリンタユニット		セツする	Time100/Rate100	100	100	1	0	97/09/12 14:04

5801	5802	5803	5804	5805
------	------	------	------	------

OPERATION ANALYSIS									
<div> <div> </div> </div>		TOTAL SIMO VALUE : 0		TOTAL MANHOUR VALUE: 15		SIMO		NEXT ELEMENT WORK	
1 SET MAIN BODY TO PREDETERMINED POSITION									
NO.	CONTENTS OF OPERATION		WF/OS	SET CONDITION	MANHOUR	USE	REMARKS		
▲ 1	XXXXXX		PU	-60/Gr1/N/>6/-3	15	0			
*									

FIG. 59

5901

<input type="radio"/> 1. PU	<input type="radio"/> 6. DSY	<input type="radio"/> 11. PU	<input type="radio"/> 16. DSY
<input type="radio"/> 2. GET	<input type="radio"/> 7. R	<input type="radio"/> 12. GET	<input type="radio"/> 17. R
<input type="radio"/> 3. M	<input type="radio"/> 8. UMAC	<input type="radio"/> 13. M	
<input type="radio"/> 4. MA	<input type="radio"/> 9. MP	<input type="radio"/> 14. MA	
<input type="radio"/> 5. ASY	<input type="radio"/> 10. BODY	<input type="radio"/> 15. ASY	

☐ SIMO

SELECT

CANCEL

5902

FIG. 61

61/97

FIG. 61

FIG. 61 is a screenshot of a software interface for defining a formula. The interface is divided into several sections:

- FORMULA:** A text box at the top left containing the formula $10 * m$. This box is labeled 6101.
- TURN:** A section header below the formula box.
- CHANGE DIRECTION OF BODY:** A section header below the turn section.
- MANUAL:** A section header at the bottom right of the main content area.
- Variable Definition Table:** A table with four columns: VARIABLE, VARIABLE NAME, VALUE, and UNIT. It is labeled 6102.
- Buttons:** A row of three buttons labeled SET, CANCEL, and SET VALUE, collectively labeled 6105.

The Variable Definition Table (6102) contains the following data:

VARIABLE	VARIABLE NAME	VALUE	UNIT
m :	THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION		COUNT
n :			
p :			
q :			
r :			
s :			

The value field for the first row is labeled 6104. The unit field for the first row is labeled 6103.

FIG. 62

The figure shows a graphical user interface window titled "INQUIRY OF LOG". The window contains several input fields and two buttons. The labels and their corresponding values are as follows:

- 6201**: Points to the title bar of the window.
- 6202**: Points to the "VARIATION AMOUNT" input field, which contains the value "10".
- 6203**: Points to the "USE" input field, which contains the value "0".
- 6204**: Points to the "REASON CODE" input field, which contains the value "1".
- 6205**: Points to the "OK" button.
- 6206**: Points to the "Clear" button.
- 6207**: Points to the "CHANGE REASON" dropdown menu, which currently displays "SET" and has a downward arrow icon.

The interface is designed for logging inquiries, allowing users to specify a variation amount, a use value, a reason code, and a change reason before confirming or clearing the entry.

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FIG. 63

6301 6302

CORRECTION OF CHANGE LOG

DATE

1997 09 22 O = O FROM
O BEFORE O ~

SEARCH

NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MANHOURL	(NEW) MANHOURL	PREVIOUS (PREVIOUS) MANHOURL	(PREVIOUS) USE	CHANGE DATE
▶ CH-01-01	ELECTRICAL CHECK	1	SET	10	10	0	0	1997/09/22 14.30.00

REASON CODE 1 CHANGE REASON SET

OK CtrR END

FIG. 64

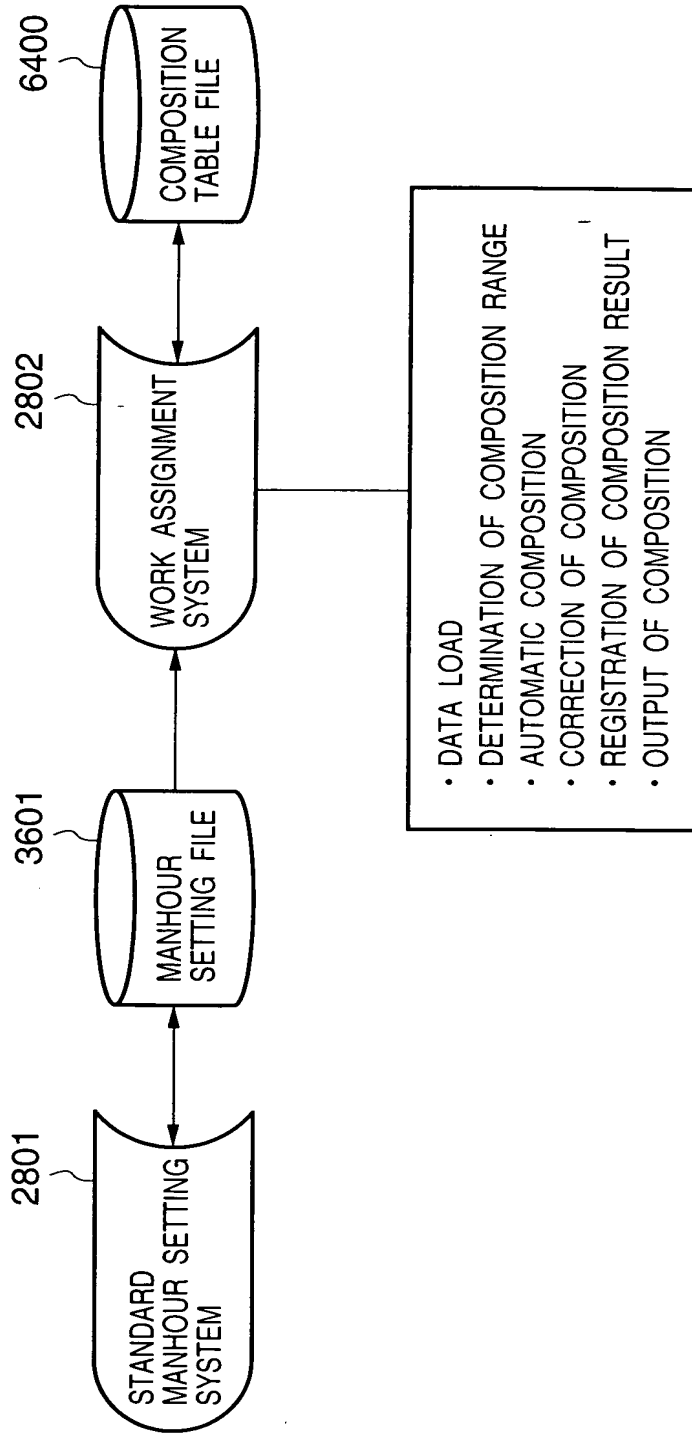


FIG. 65

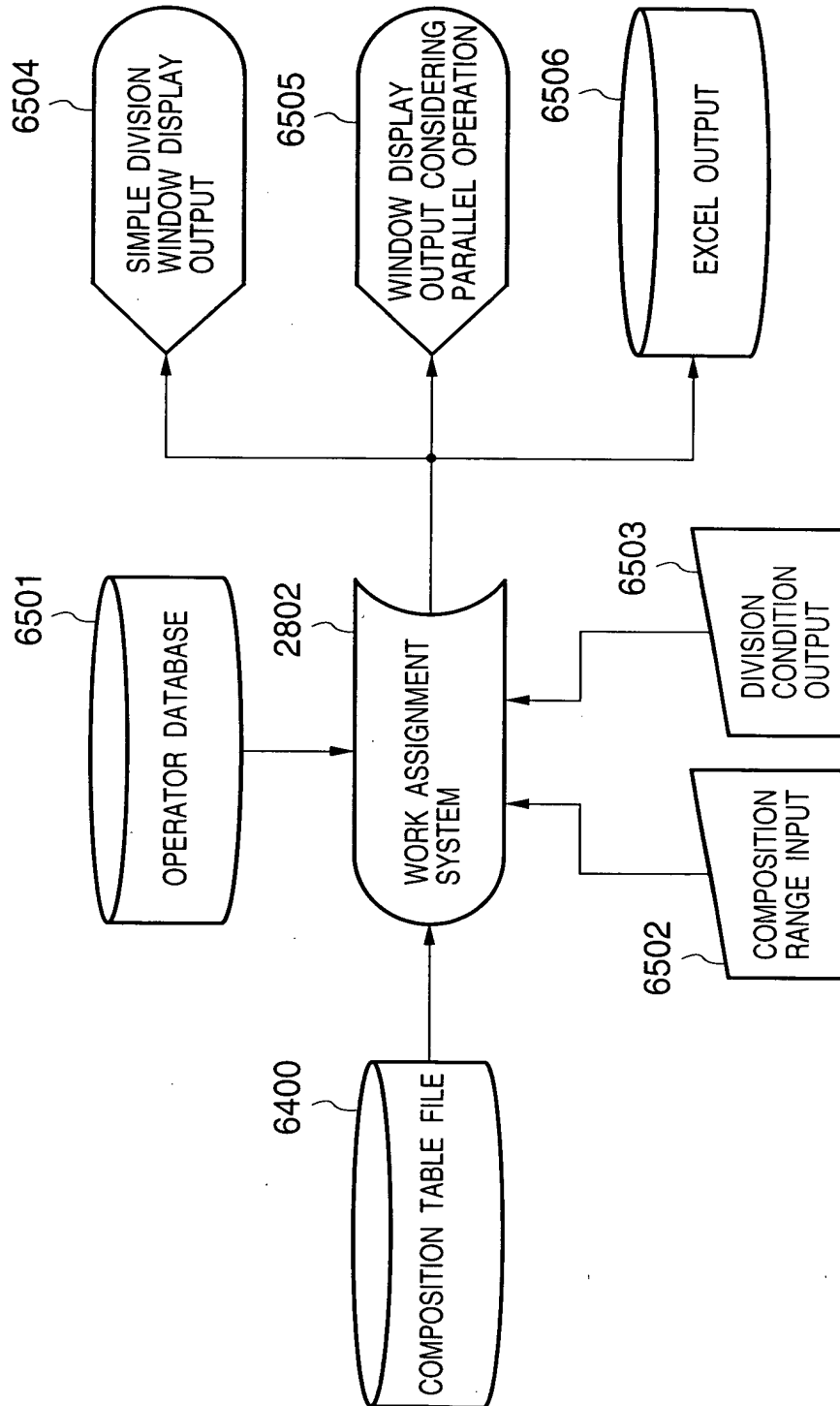


FIG. 66

WORK ORDER

66/97

STATION 1
 $t_1 \doteq P_T$

STATION 2
 $t_2 \doteq P_T$

STATION n-1
 $t_{n-1} \doteq P_T$

STATION n
 $t_n \doteq P_T$

FIG. 67

		▶	▲
FILE(F) EDIT(E) INPUT(I) TOOL(O)			
<div>MODEL</div> <div>GP55</div> <div>UNIT</div> <div></div>			
STANDARD NO.	WORK NAME	MANHOUR	
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	

: :

SIMPLE DIVISION
PARALLEL DIVISION

FIG. 68

SIMPLE DIVISION

		▼	▲
	FILE(F) EDIT(E)	◆	
St 1			
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
St 2			
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	
⋮			

FIG. 69

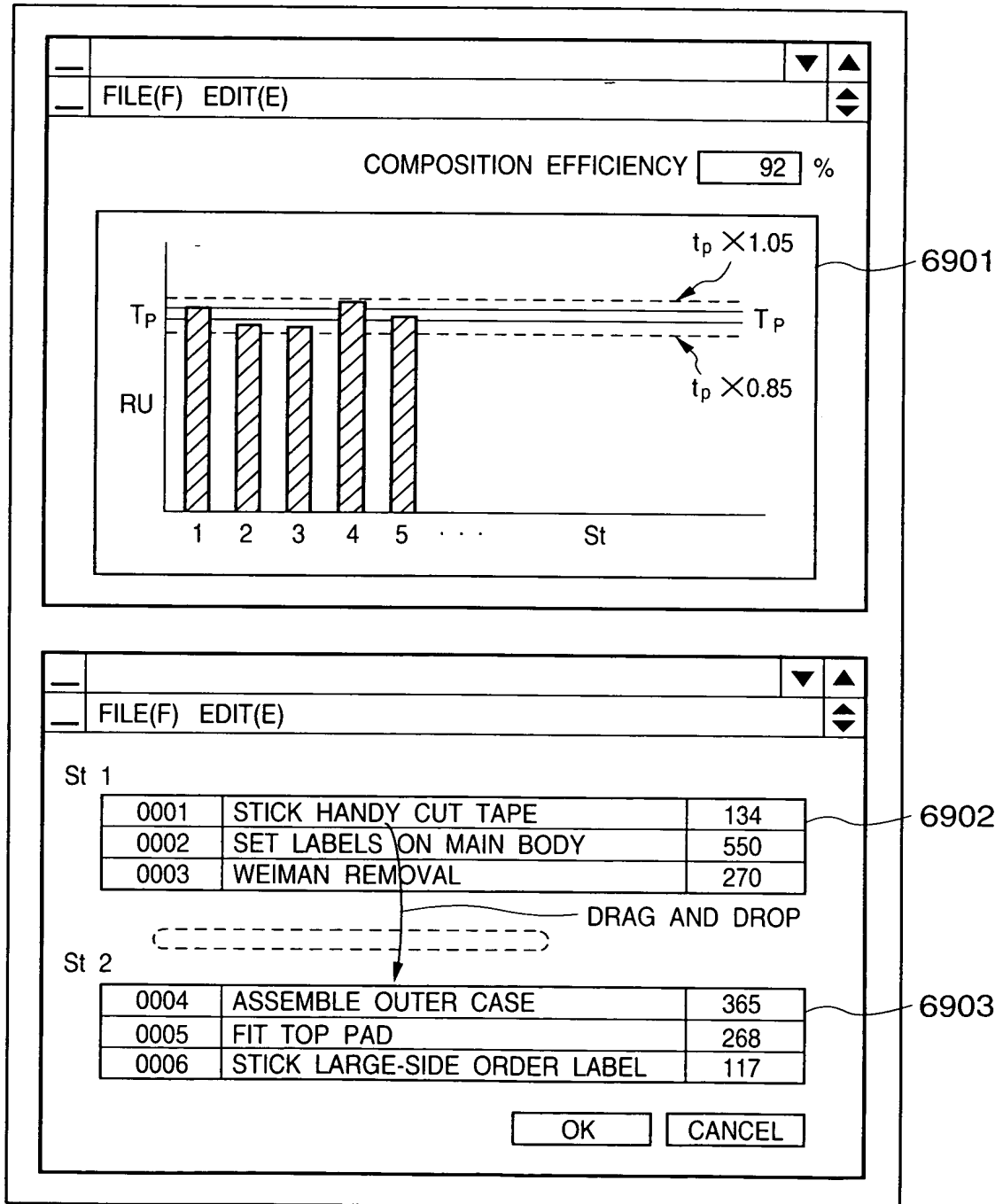
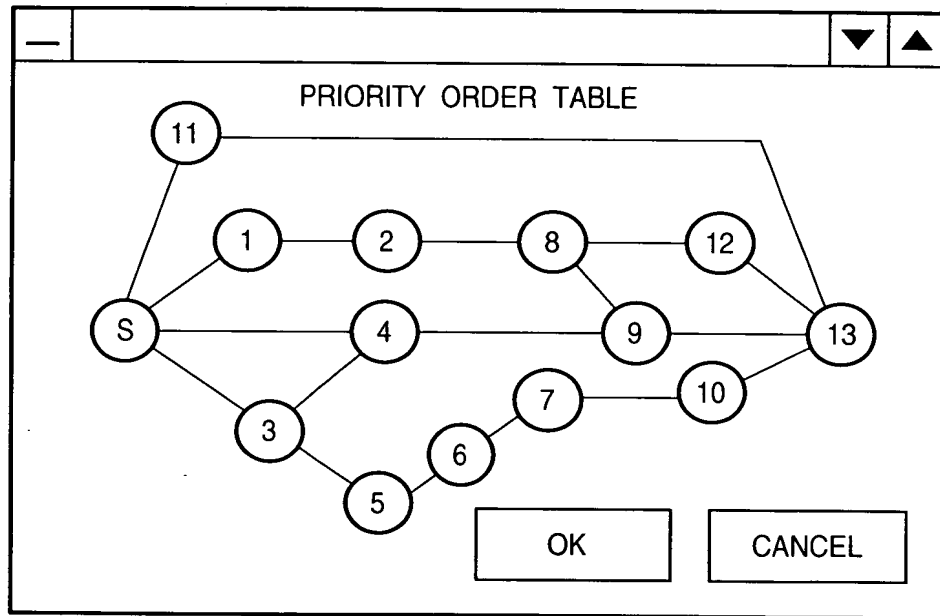


FIG. 70

71/97

FIG. 71

PARALLEL DIVISION

				▼	▲
PLAN 2		PLAN 1			
St 1		St 1			
1		1	STICK HANDY CUT TAPE	99	
2		2	SET LABELS ON MAIN BODY	78	
8		3	WEIMAN REMOVAL	134	
St 2		St 2			
3		4	ASSEMBLE OUTER CASE	732	
4		5	FIT TOP PAD	268	
5		6	STICK LARGE-SIDE ORDER LABEL	117	
			⋮		

FIG. 72

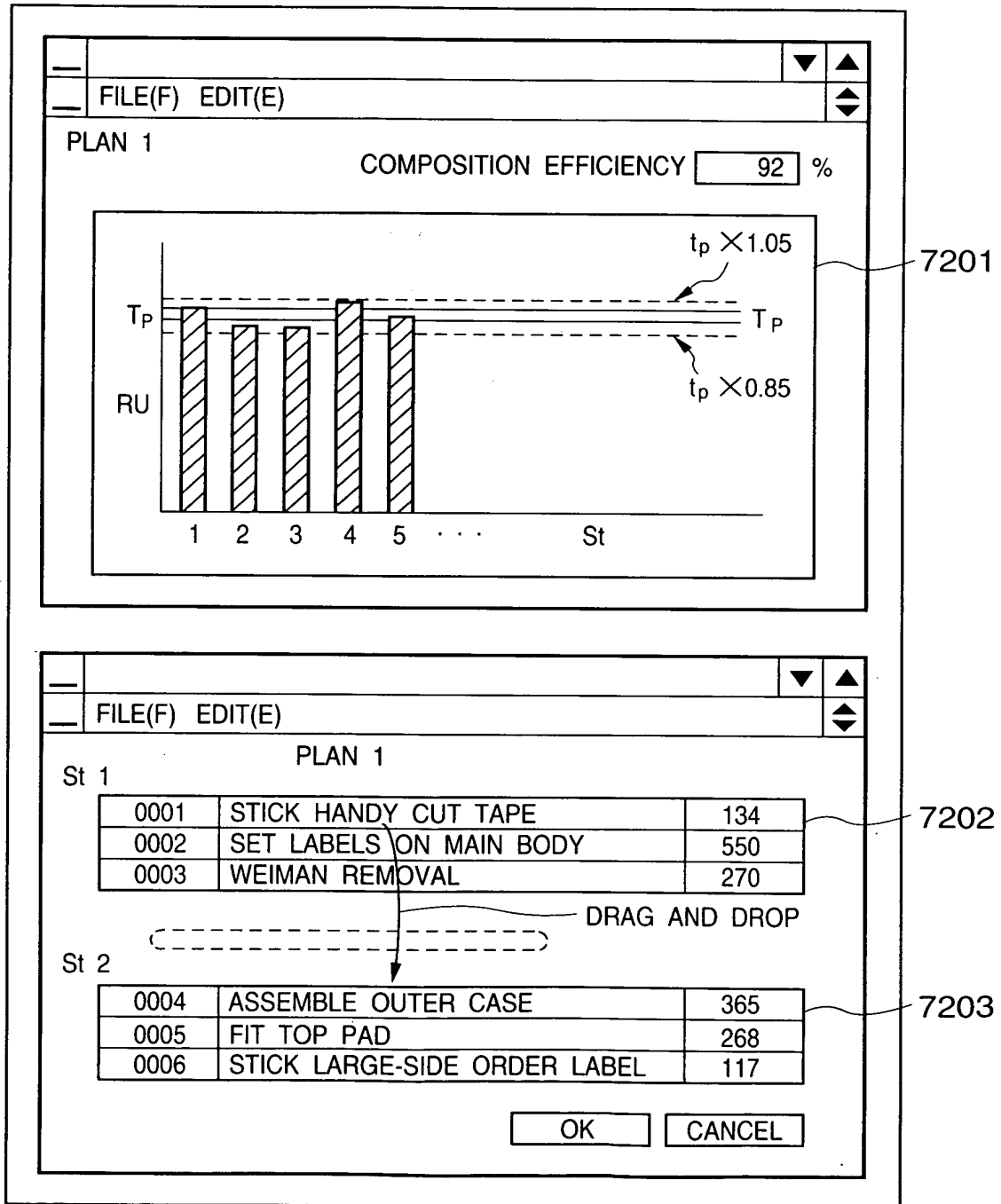


FIG. 73

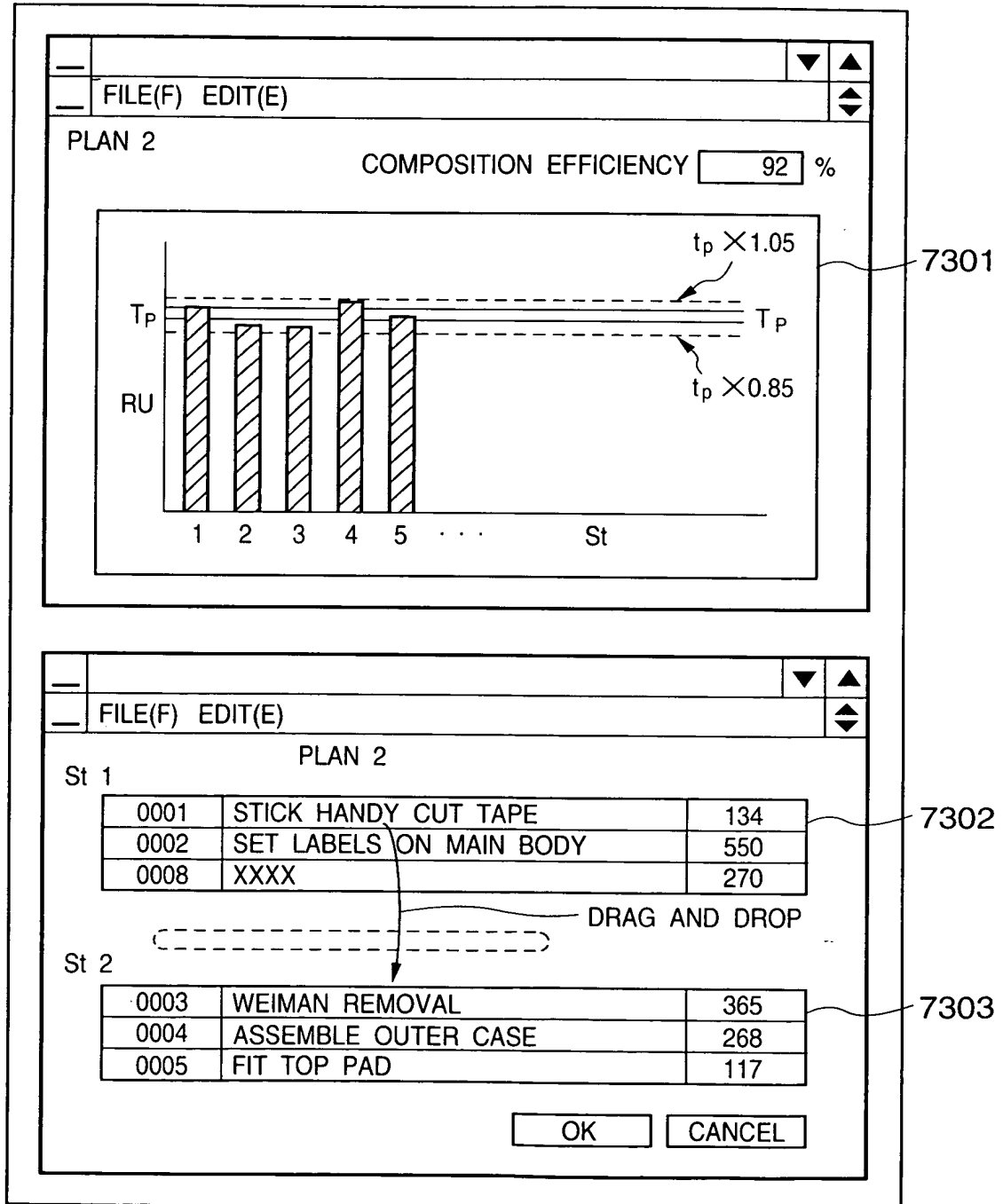


FIG. 74

74/97

7403

LOAD OF NEWLY COMPOSED DATA (MANHOUR)

7401

7402

7404

7405

7406

7407

7409

7408

OK

CANCEL

GENRE

REPRESENTATIVE MODEL

TARGET MODEL

COMPONENT

COMPONENT SYMBOL

COMPONENT NAME

ORDER

BJ
FAX
LBP
NP
STAND

X

FIG. 75

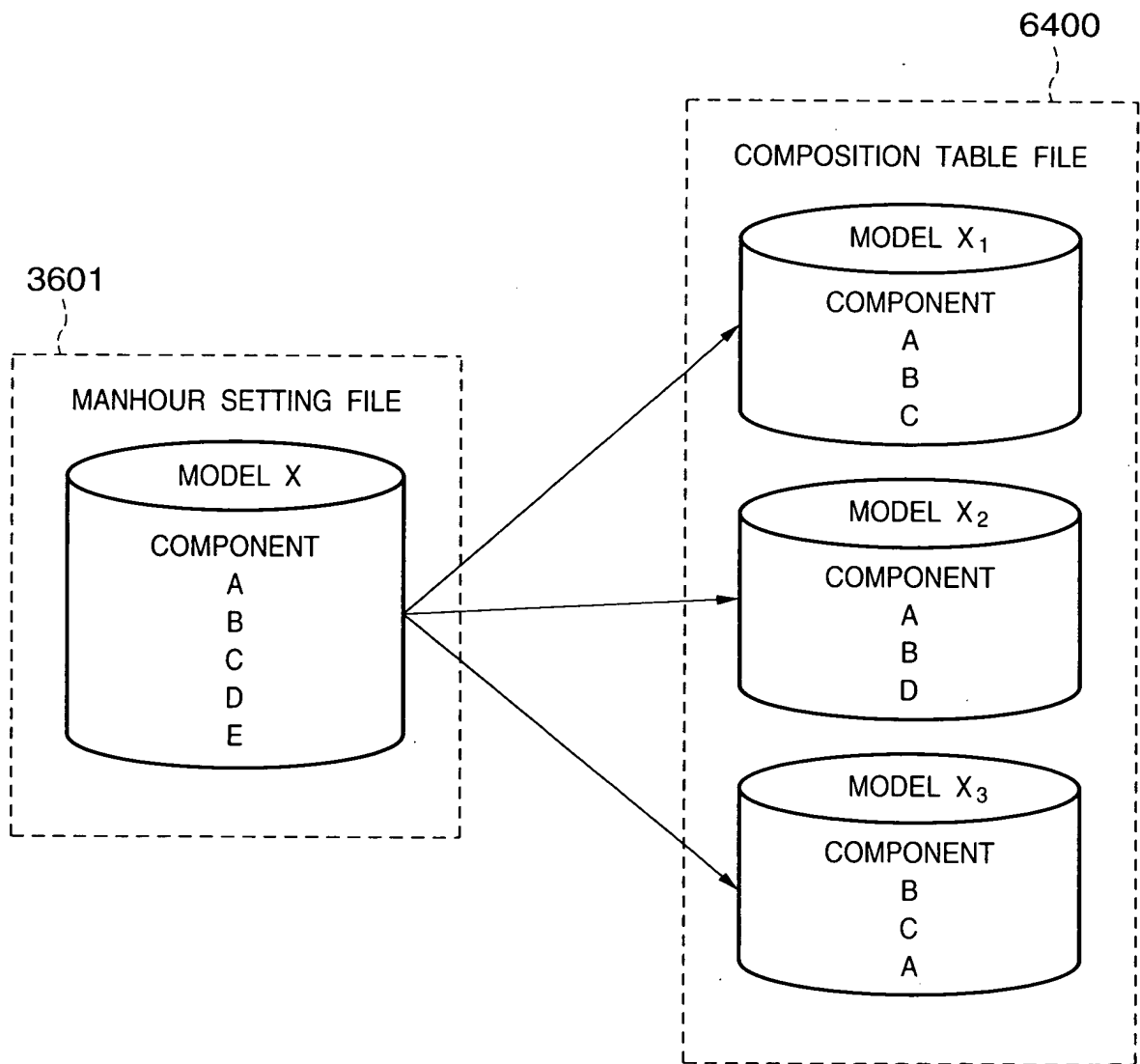


FIG. 76

7601

7602

7603

7604

OPEN FILE

TARGET MODEL

NAME

REVISION NUMBER

SAVE DATE

ファイル名	テストデータ(元)	テスト	1	97/09/19 12:00:34
f12-0010.csv			1	97/09/19 12:00:34
f12-0010.csv			0	97/09/19 13:27:17
BJC-4300		0	0	97/09/19 14:10:14
BJC-4300		0	0	97/09/19 14:10:32
BJC-4300			1	97/09/19 15:41:14
BJC-4300	BJC-4300Aライン編成			97/09/20 14:16:58
BJC-4300	BJC-4300Aライン編成		03	97/10/13 17:54:57
BJC-4300	BJC-4300Aライン編成		00	97/09/20 14:06:36
f12-0010.csv	f12-0010Aライン編成		05	97/09/24 17:11:53

SELECT WINDOW

○ COMPOSITION DATA INPUT WINDOW

○ COMPOSITOR DATA CORRECTION WINDOW

OK

CANCEL

7606

FIG. 77

[illegible]

FIG. 78

INSERTION OF UNIT WORK

NEW WORK WILL BE INSERTED BEFORE
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

UNIT WORK NAME :

PROVISIONAL MANHOUR : (RU)

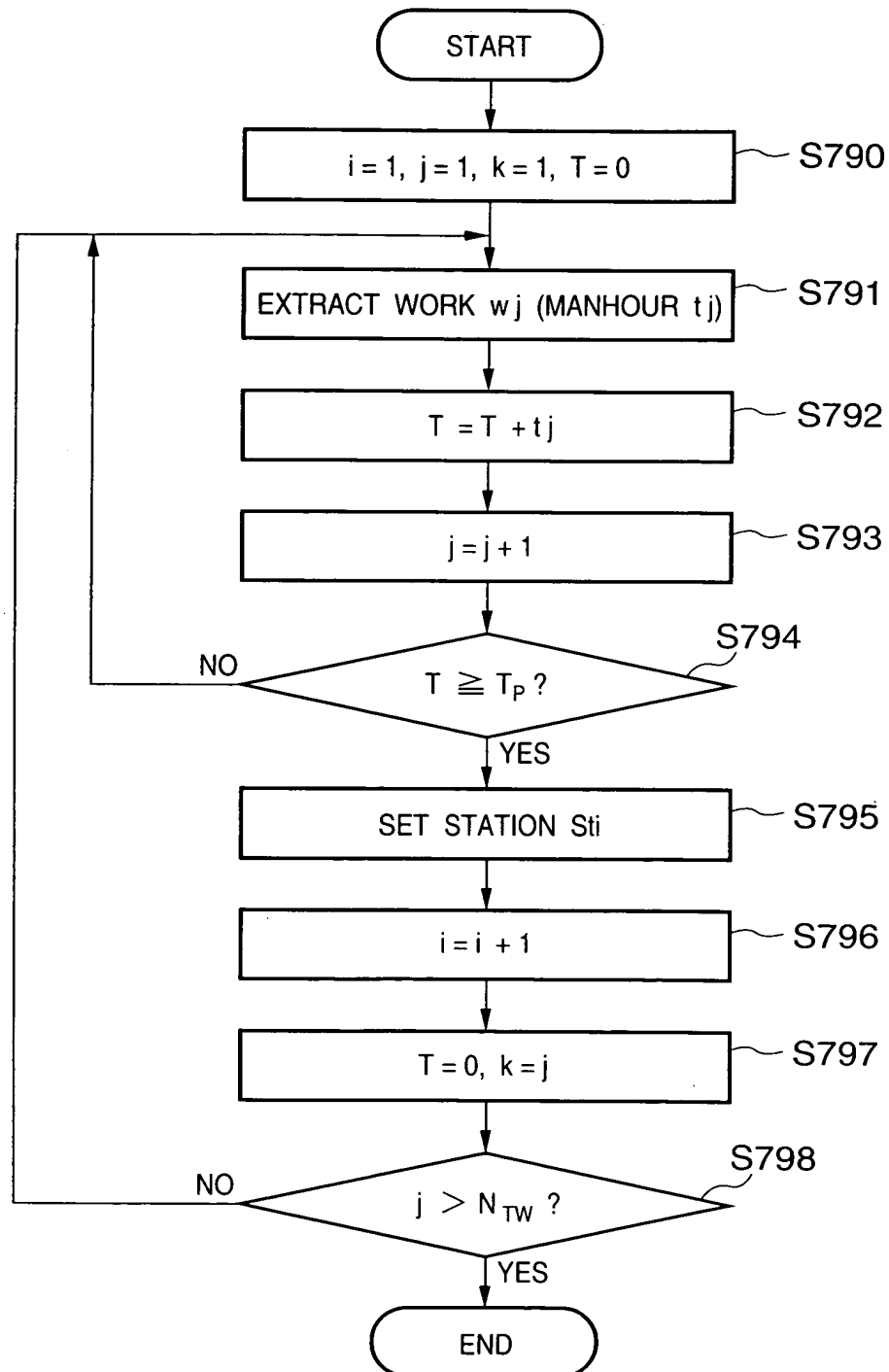
REMARKS :

OK CANCEL

7801

7802

FIG. 79



FILE(F) EDIT(E) VIEW(V) TOOL(T)

3006

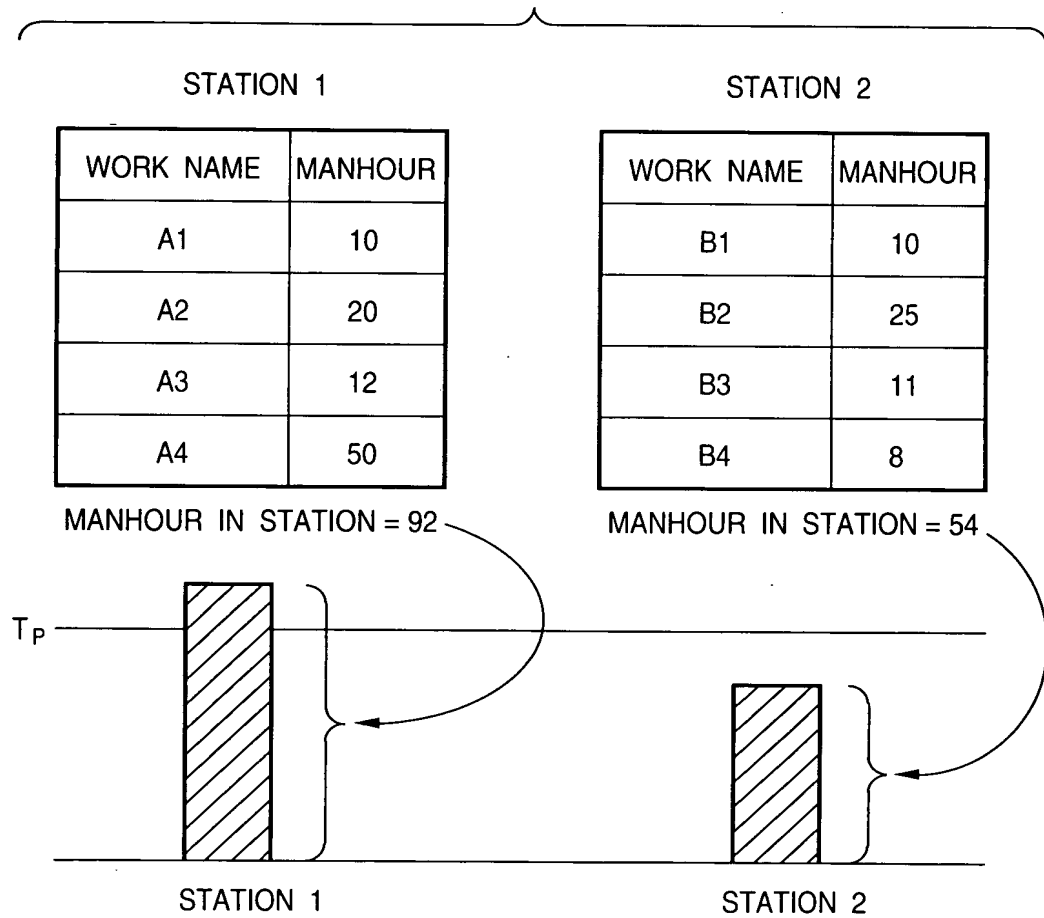
FIG. 81

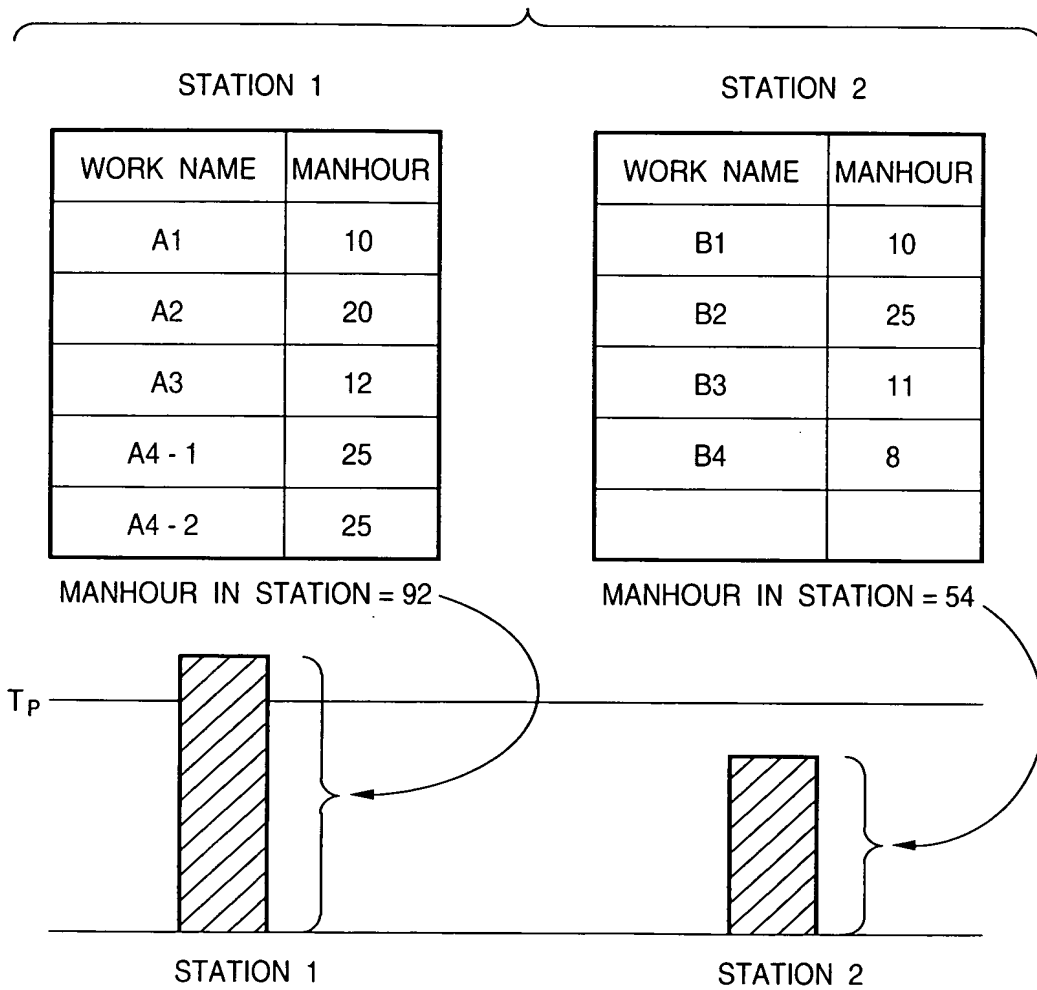
FIG. 82

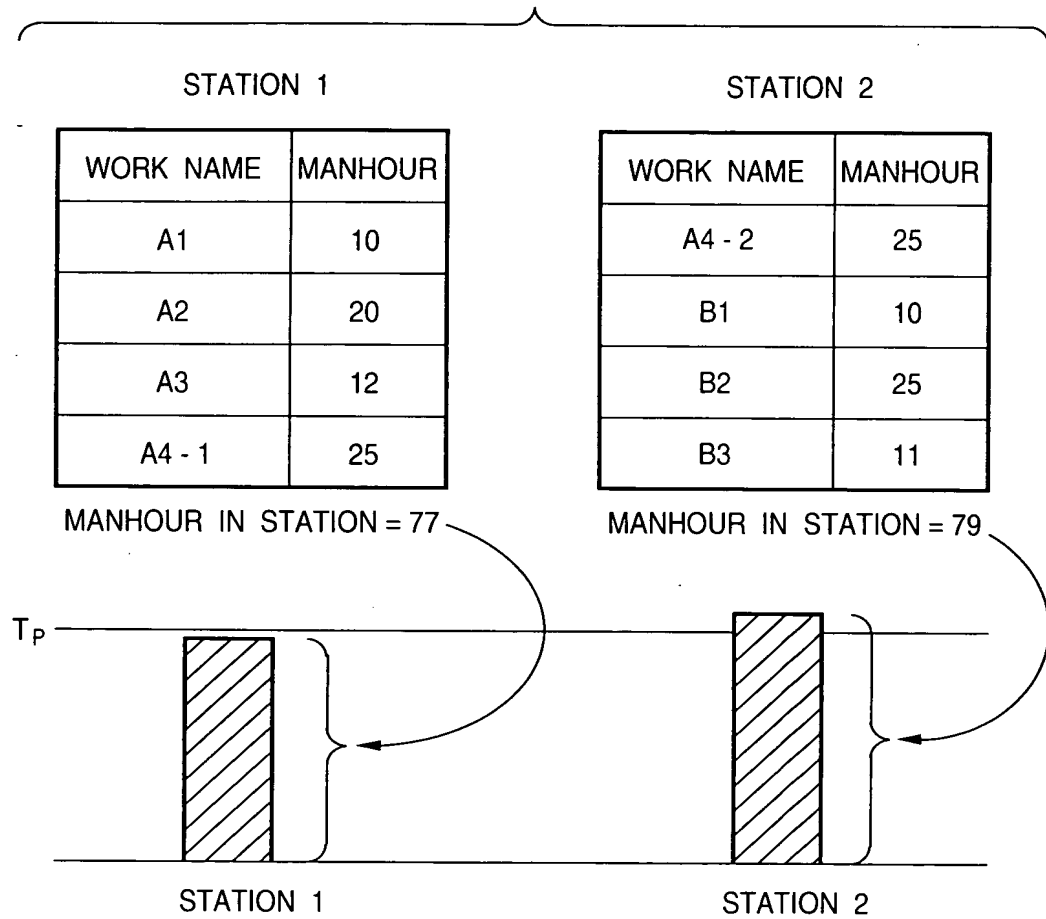
FIG. 83

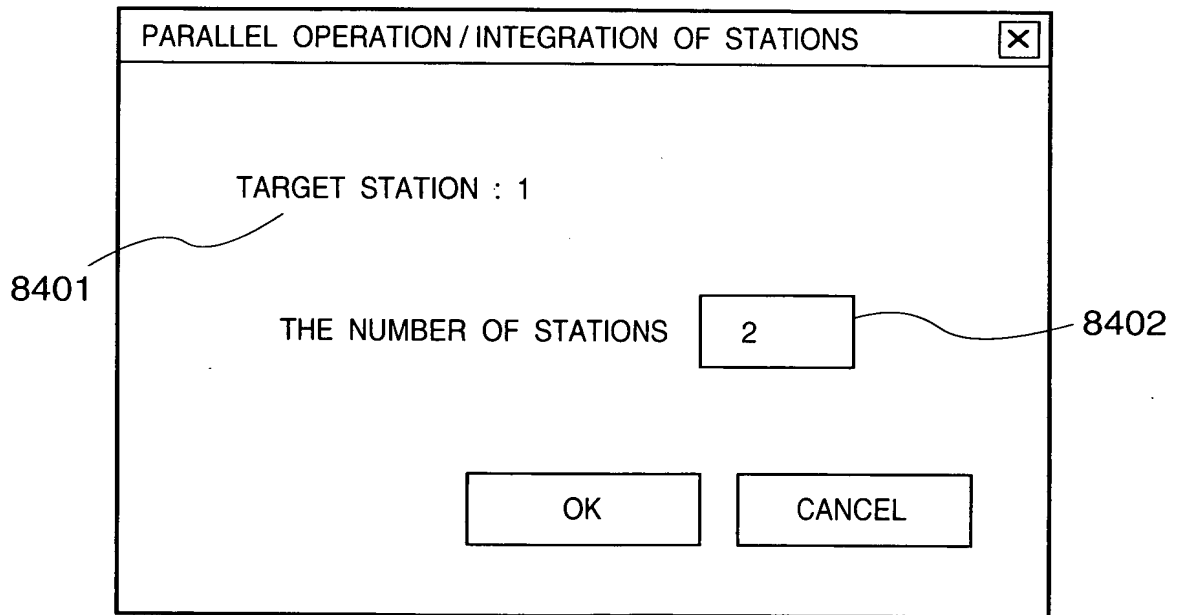
FIG. 84

FIG. 85

FILE(E) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MA-CHINE UAL
START	0	0	No.
UNIT WORK NAME 1	34	10	No.01
UNIT WORK NAME 2	255	46	No.02
UNIT WORK NAME 6	92	26	No.06
UNIT WORK NAME 7	52	0	No.07
UNIT WORK NAME 8	52	0	No.08
UNIT WORK NAME 9	0	36	No.09

TOTAL 585 (RU) PF 83.6%

OPERATOR 2

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MA-CHINE UAL
UNIT WORK NAME 3	156	0	No.03
UNIT WORK NAME 4	34	0	No.04
UNIT WORK NAME 5	138	23	No.06
UNIT WORK NAME 10	71	48	No.10
UNIT WORK NAME 11	138	30	No.11
UNIT WORK NAME 12	97	20	No.12
UNIT WORK NAME 13	88	0	No.14
UNIT WORK NAME 14	46	18	No.15
UNIT WORK NAME 15	546	15	No.16
UNIT WORK NAME 17	58	20	No.17

TOTAL 1548 (RU) xxxxxx PF 23.5 %

OPERATOR 3

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MA-CHINE UAL
UNIT WORK NAME 13	30	40	No.13
UNIT WORK NAME 16	303	131	No.18

TOTAL 572 (RU) PF 96.7%

OPERATOR 4

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MA-CHINE UAL
UNIT WORK NAME 19	84	26	No.19
UNIT WORK NAME 20	120	20	No.20
UNIT WORK NAME 21	310	66	No.21

TOTAL 623 (RU) PF 95.2%

OPERATOR 5

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MA-CHINE UAL
UNIT WORK NAME 22	146	71	No.22
UNIT WORK NAME 23	106	26	No.23
UNIT WORK NAME 24	61	0	No.24
UNIT WORK NAME 25	51	10	No.25
END	0	0	No.X

TOTAL 486 (RU) PF 73.6%

PARALLEL STATIONS

STATION	1	2	3	4	5
900					
720					
540					
360					
180					
0					

G STANDARD NO. WORK NAME

WF MEANS MA-CHINE MAN-CHINE HOUR

PROVISIONAL REMARKS

COMPOSITION EFFICIENCY 116 %

NET COMPOSITION EFFICIENCY %

COMPOSITION MODE : PRIORITY ORDER SCHEME

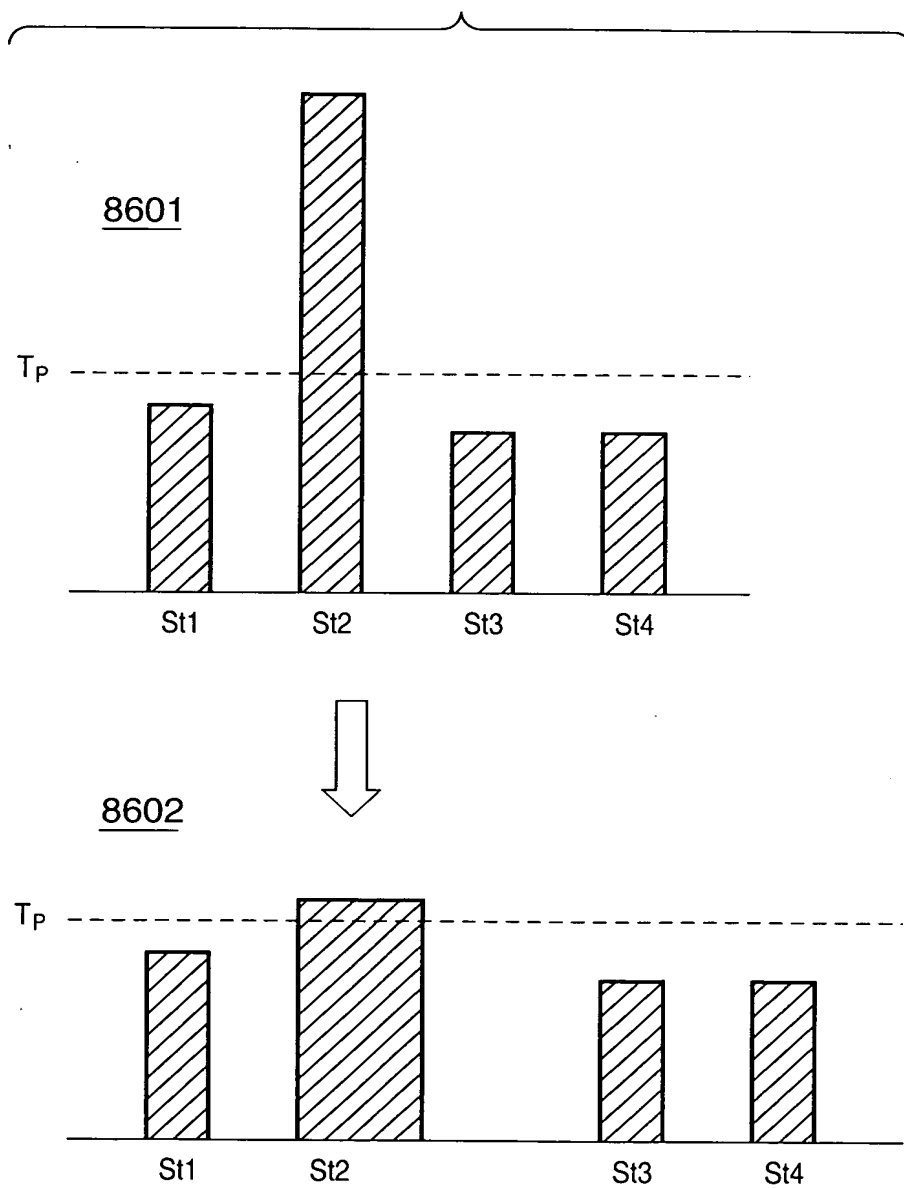
FIG. 86

FIG. 87

A diagram of a 'USER REGISTRATION' dialog box. The dialog box has a title bar with a close button (X). Inside, there are five input fields and two buttons. Each input field is connected to a reference number (8701 to 8705) by a curved line. The fields are: 'NAME CODE' (text box with '12345'), 'NAME' (two text boxes with '田中' and '一郎'), 'POSITION' (text box with 'kumitate' and a dropdown arrow), 'PASSWORD' (text box with '12345'), and 'AUTHORITY' (empty text box). The buttons are 'OK' and 'CANCEL'.

USER REGISTRATION

NAME CODE : 12345 8701

NAME : 田中 一郎 8702

POSITION : kumitate ▼ 8703

PASSWORD : 12345 8704

AUTHORITY : 8705

OK CANCEL

MERGE



FIG. 89

DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...
yyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...
zzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...

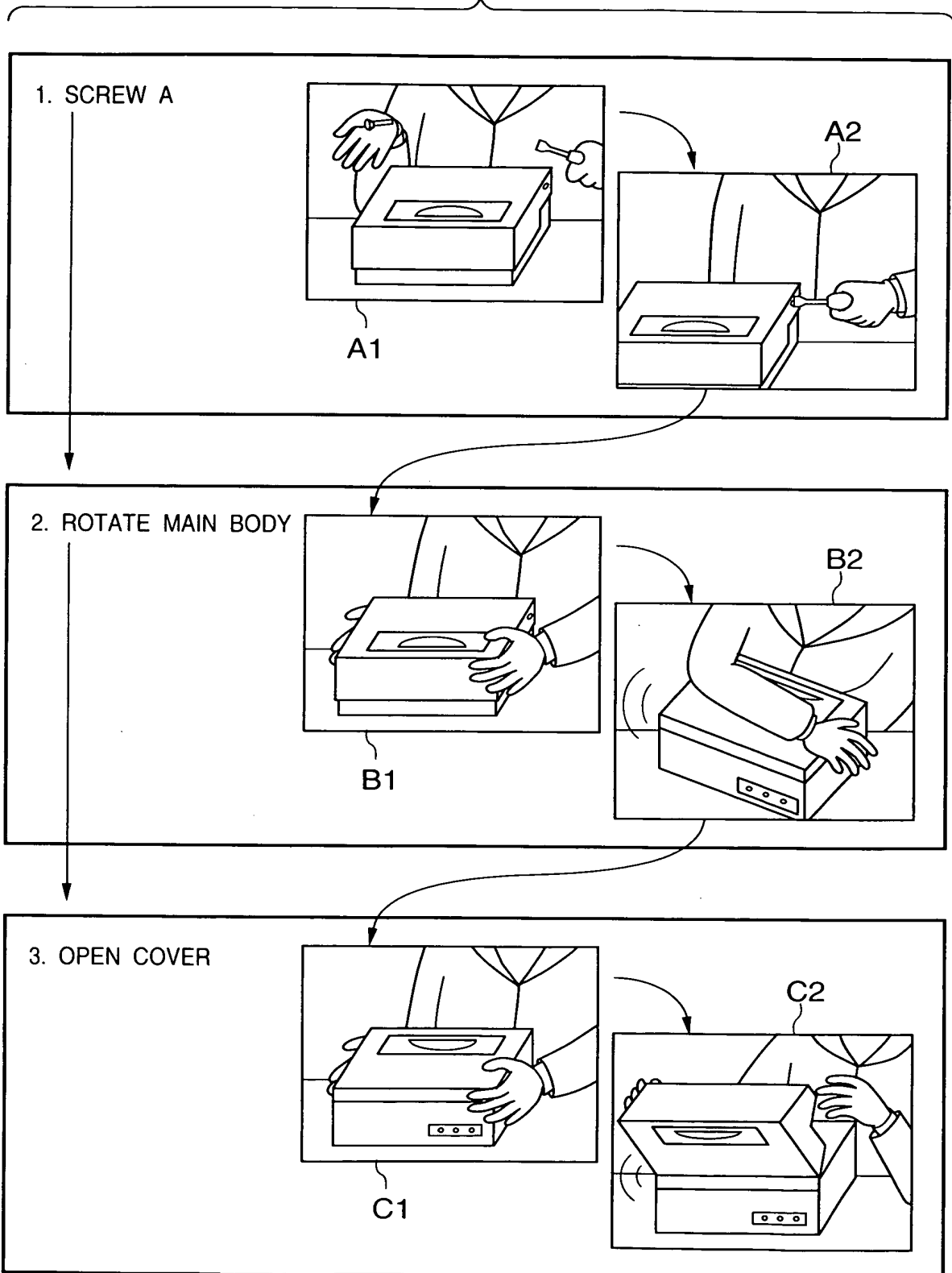
FIG. 90

FIG. 91

9101 9102

SETTING OF COMPONENT SYMBOL

PRODUCT SYMBOL : BJ - 970909

COMPONENT SYMBOL : CH

COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

FIG. 92

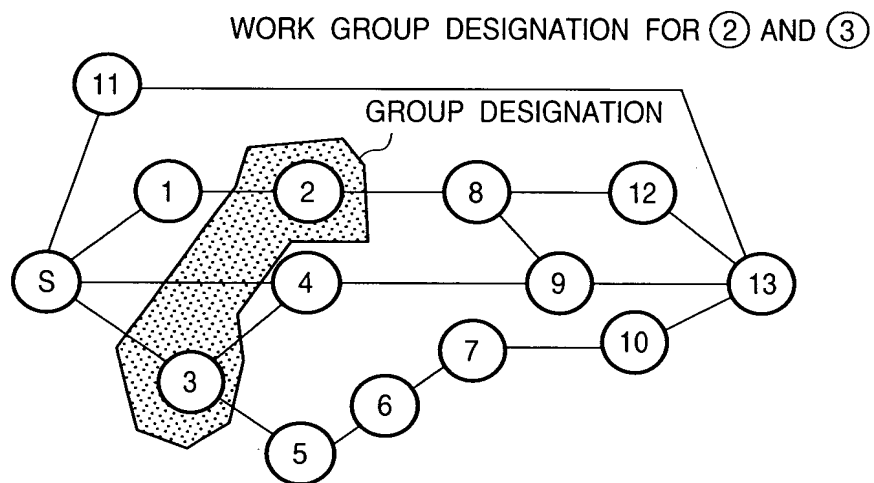


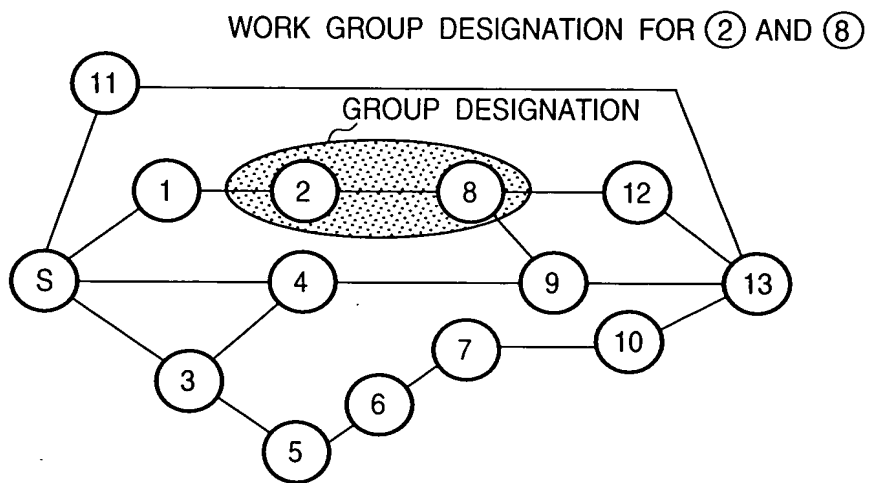
FIG. 93

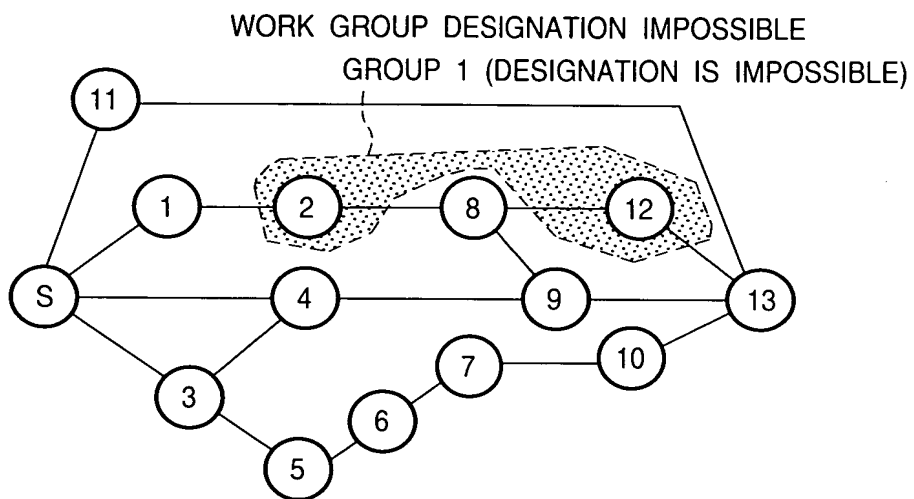
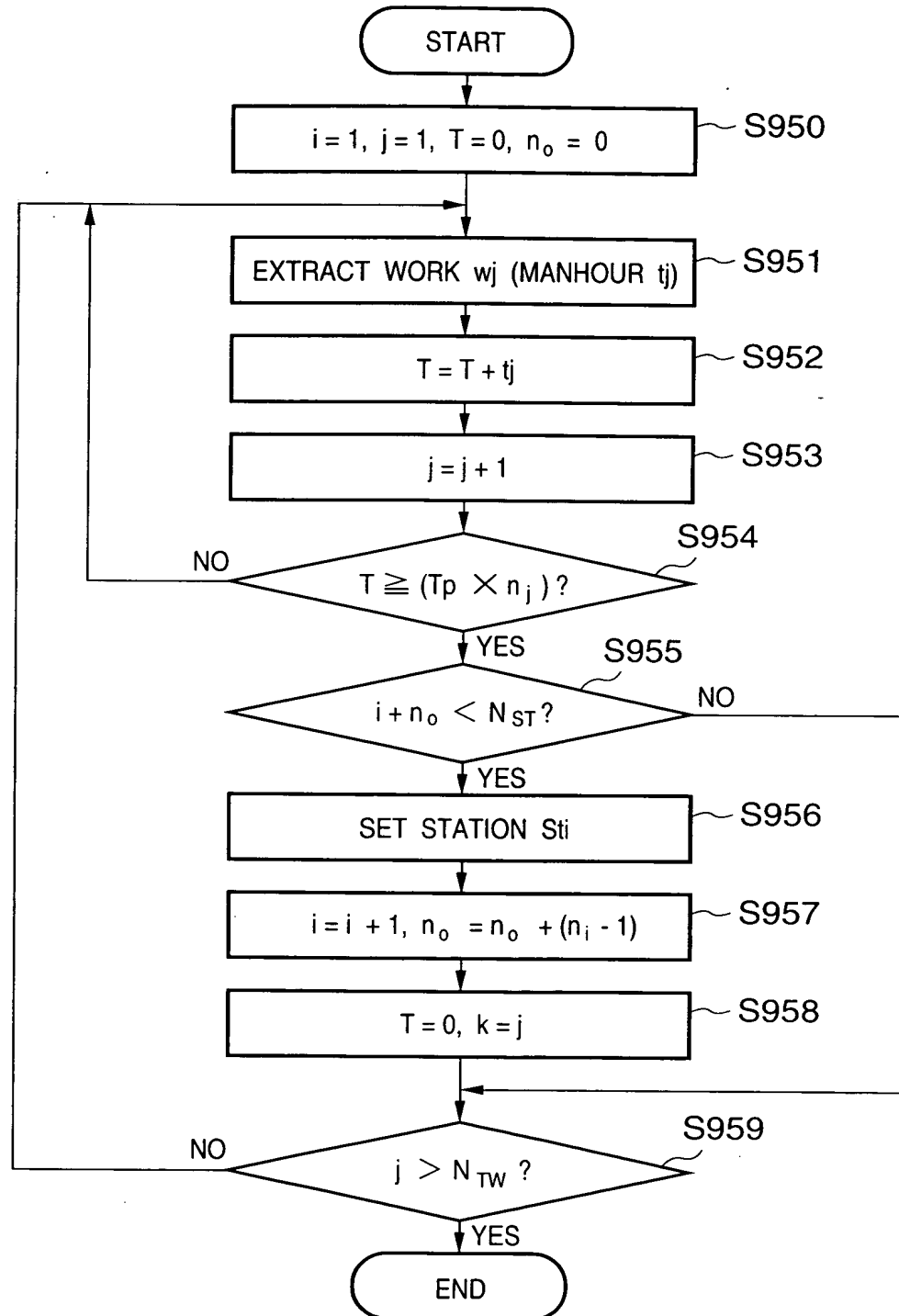
FIG. 94

FIG. 95



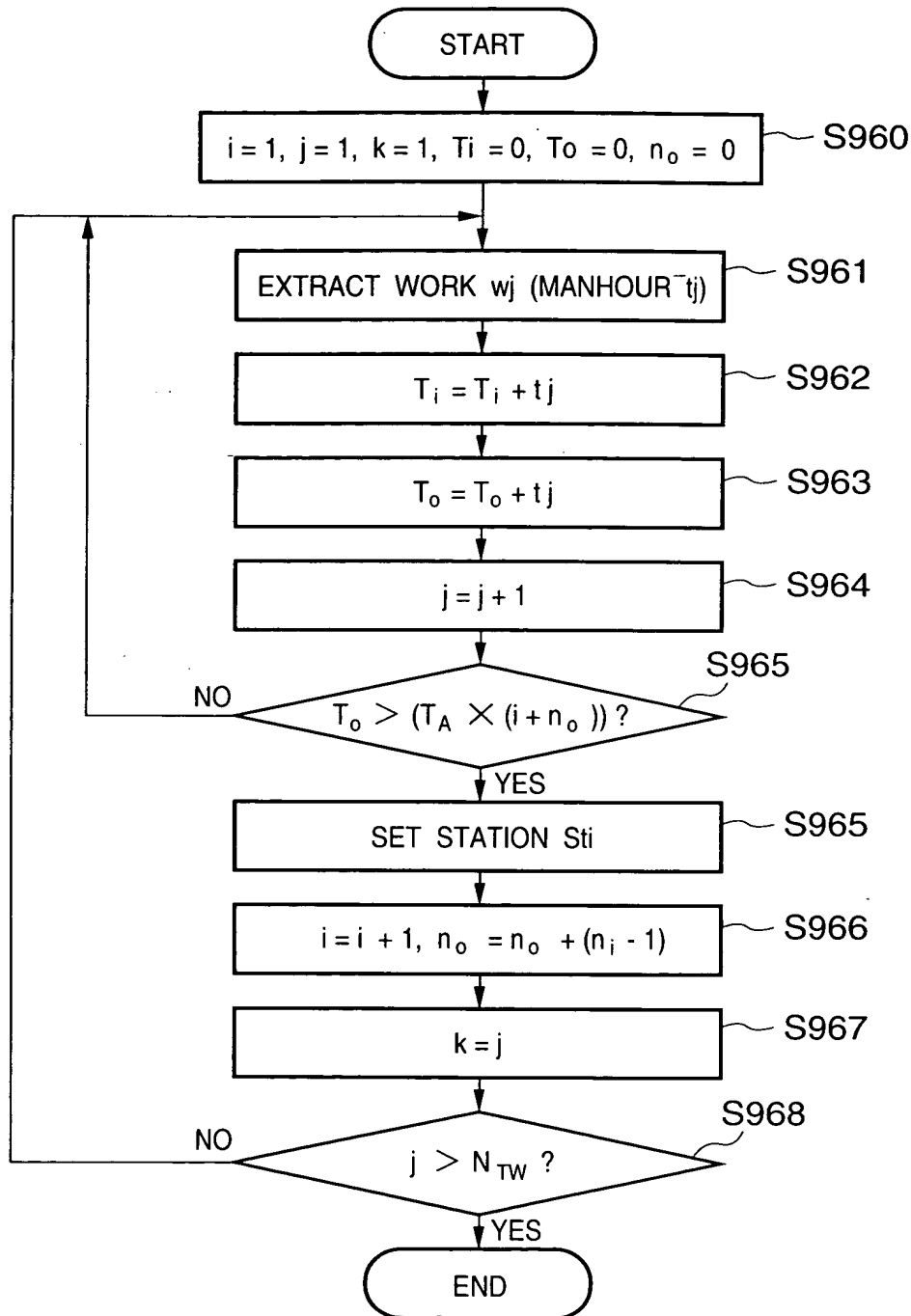
N_{ST} : THE NUMBER OF STATIONS

n_i : i STATION PARALLEL NUMBER

n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

96/97

FIG. 96



N_{ST} : THE NUMBER OF STATIONS

T_i : i STATION MANHOUR

T_A : STATION MANHOUR AVERAGE VALUE

$$T_A = WF / N_{ST}$$

T_o : TOTAL ACCUMULATED MANHOUR

n_i : i STATION PARALLEL NUMBER

n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

FIG. 97

FILE(E) EDIT(E) VIEW(D) TOOL(T)

OPERATOR 1

S1

WORK NAME	WF	PROV. SIONAL MAN-CHINE UAL	MA-CHINE UAL
START	0	0	No.
UNIT WORK NAME 1	34	10	No.01
UNIT WORK NAME 2	255	46	No.02
UNIT WORK NAME 6	92	26	No.06
UNIT WORK NAME 7	52	0	No.07
UNIT WORK NAME 8	52	0	No.08
UNIT WORK NAME 9	0	36	No.09

TOTAL 585 (RU)

OPERATOR 2

S2

WORK NAME	WF	PROV. SIONAL MAN-CHINE UAL	MA-CHINE UAL
UNIT WORK NAME 3	156	0	No.03
UNIT WORK NAME 4	34	0	No.04
UNIT WORK NAME 5	138	23	No.08
UNIT WORK NAME 10	71	48	No.10
UNIT WORK NAME 11	138	30	No.11
UNIT WORK NAME 12	97	20	No.12
UNIT WORK NAME 13	88	0	No.14
UNIT WORK NAME 14	46	18	No.15
UNIT WORK NAME 15	546	15	No.16
UNIT WORK NAME 17	58	20	No.17

TOTAL 1548 (RU) xxxxxxx

OPERATOR 3

S3

WORK NAME	WF	PROV. SIONAL MAN-CHINE UAL	MA-CHINE UAL
UNIT WORK NAME 13	30	40	No.13
UNIT WORK NAME 16	303	131	No.18

TOTAL 572 (RU)

OPERATOR 4

S4

WORK NAME	WF	PROV. SIONAL MAN-CHINE UAL	MA-CHINE UAL
UNIT WORK NAME 19	84	26	No.19
UNIT WORK NAME 20	120	20	No.20
UNIT WORK NAME 21	310	66	No.21

TOTAL 6238 (RU)

OPERATOR 5

S5

WORK NAME	WF	PROV. SIONAL MAN-CHINE UAL	MA-CHINE UAL
UNIT WORK NAME 22	146	71	No.22
UNIT WORK NAME 23	106	26	No.23
UNIT WORK NAME 24	61	0	No.24
UNIT WORK NAME 25	51	10	No.25
END	0	0	No.X

TOTAL 486 (RU)

OPERATOR 6

S6

TOTAL 73.6%

PARALLEL STATIONS

PF 83.6% PARALLEL STATIONS PF 117.3%

G	STANDARD NO.	WORK NAME	WF	MEANS	MA-CHINE	PROVISIONAL	REMARKS
1	tp						
2	tp*1.05						
3	tp*0.85						
4	t						
5							

COMPOSITION MODE: PRIORITY ORDER SCHEME

COMPOSITION EFFICIENCY 96.43%

NET COMPOSITION EFFICIENCY